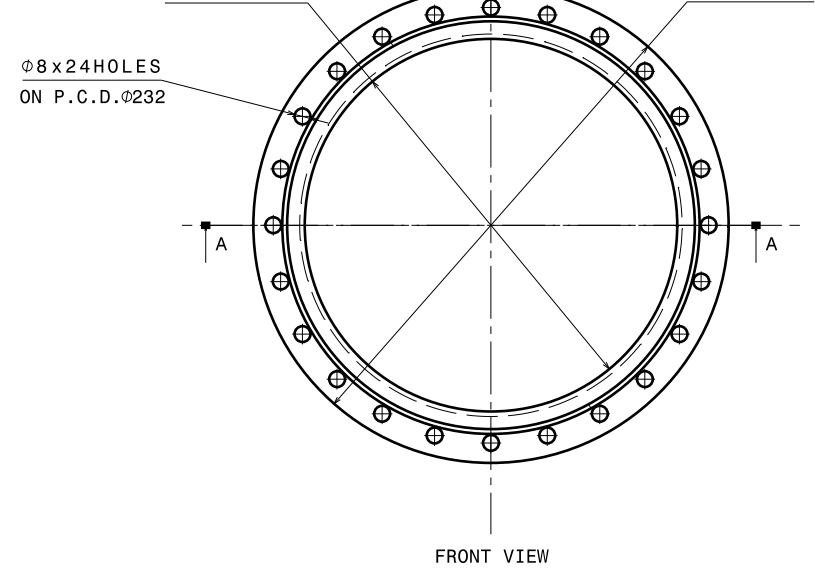
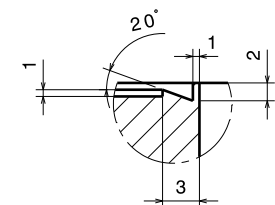
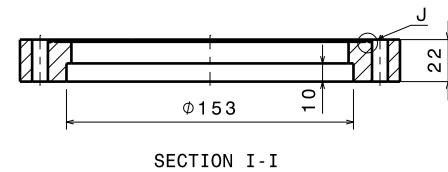
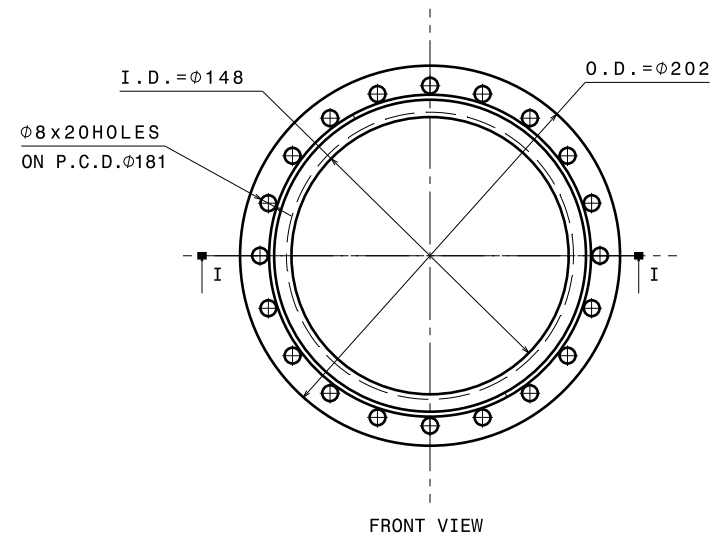
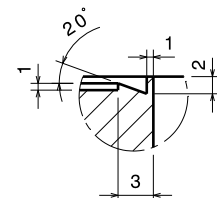
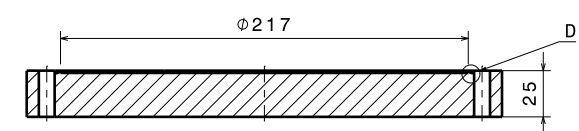
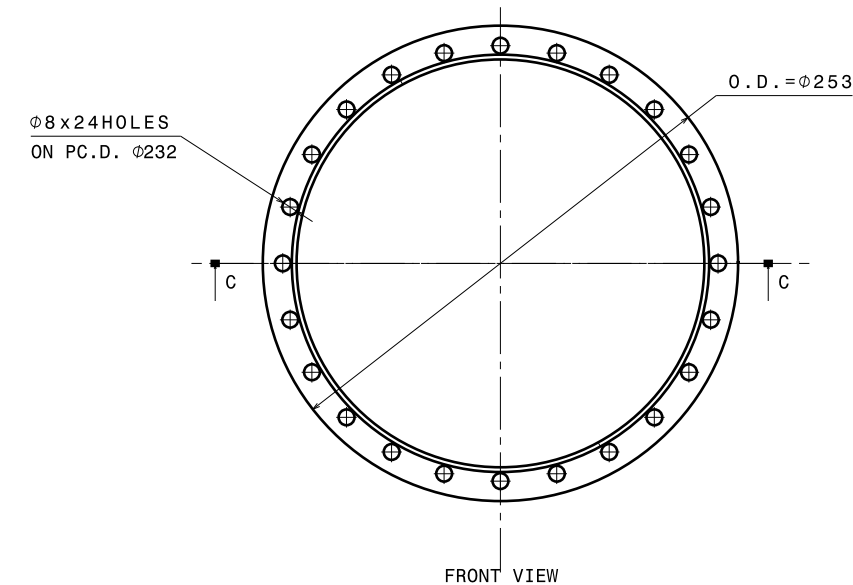


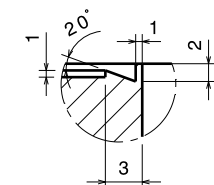
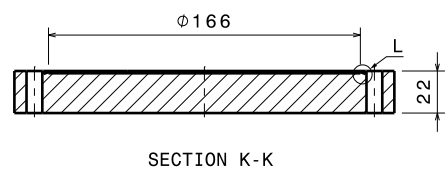
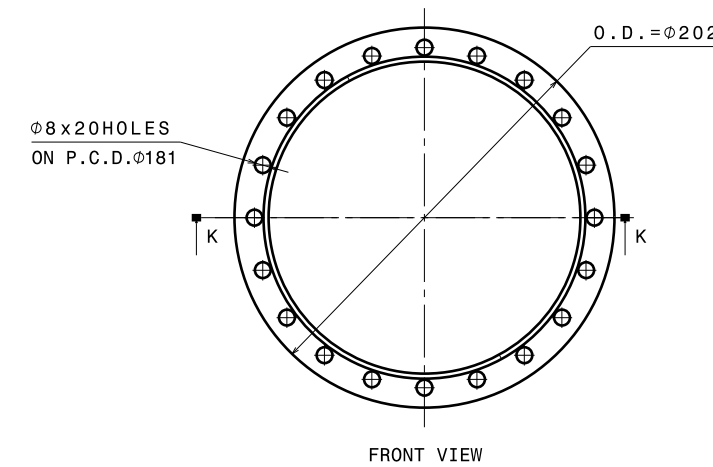
DN 200CF BLANK FLANGE



DN 160CF BLANK FLANGE

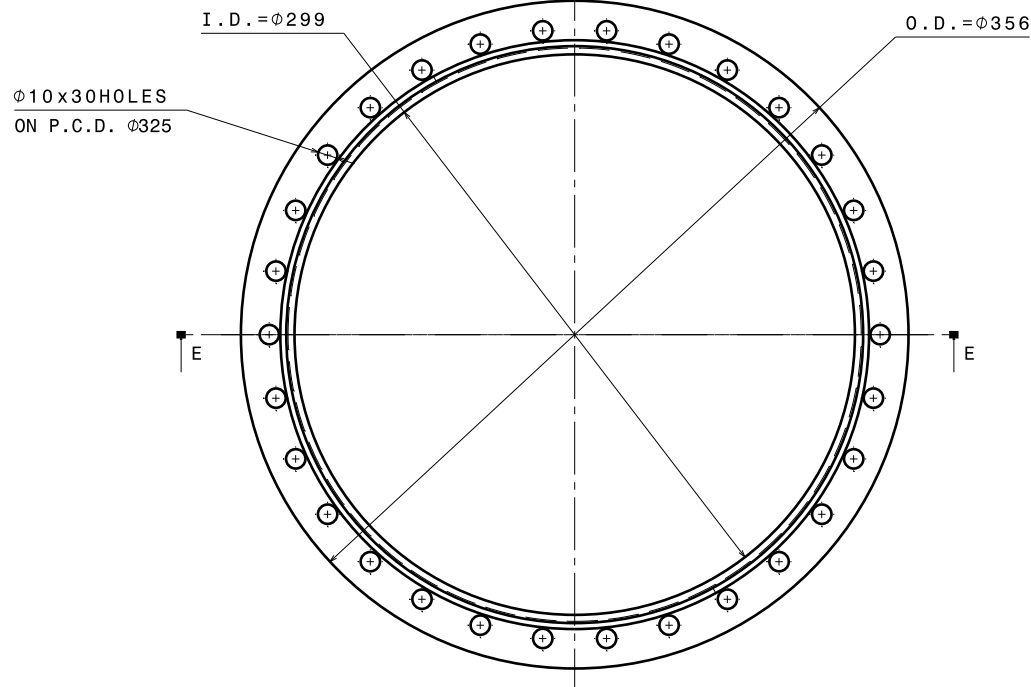


DN 200CF COVER FLANGE

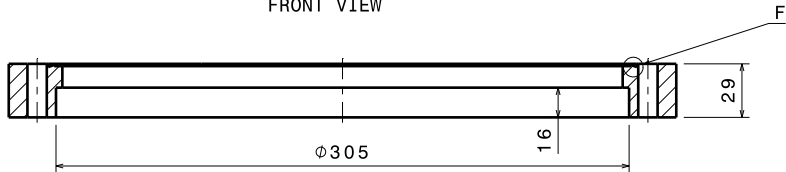


DN 160CF COVER FLANGE

MATERIAL:				▽ 8-25	▽▽ 1.6-8	▽▽▽ 0.025-1.6	▽▽▽▽ < 0.025	REVISION COLUMN						MED		SIZE A1			INSTITUTE FOR PLASMA RESEARCH (LIGO-INDIA) BHAT, GANDHINAGAR-382 428.	
CO-ORDINATED BY								REV	ZONE	DESCRIPTION	DATE	REMARKS	APPROVED BY	ALL DIMENSIONS ARE IN mm UNLESS OTHERWISE STATED						
MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS														SCALE	1:2	DATE		TITLE STANDARD FLANGES		
LENGTH IN mm OF SHORTER SIDE OF ANGLES				LENGTH OR DIA	UPTO 6	6-30	30-120	120-315						DRAWN	A.N.N.	04/06/2014				
UPTO 10	10-50	50-120	OVER 120-400		+0.1	+0.2	+0.3	+0.5						CHECKED	R.K.		REF DRG NO: NA	REV R0		
±1°	±0°-30'	±0°-20'	±0°-10'											APPROVED	M.K.G.		DRG.NO V001-001-R0	SHEET 01 OF 05		

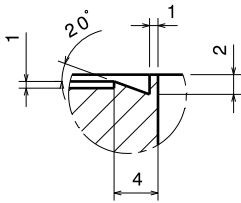


FRONT VIEW

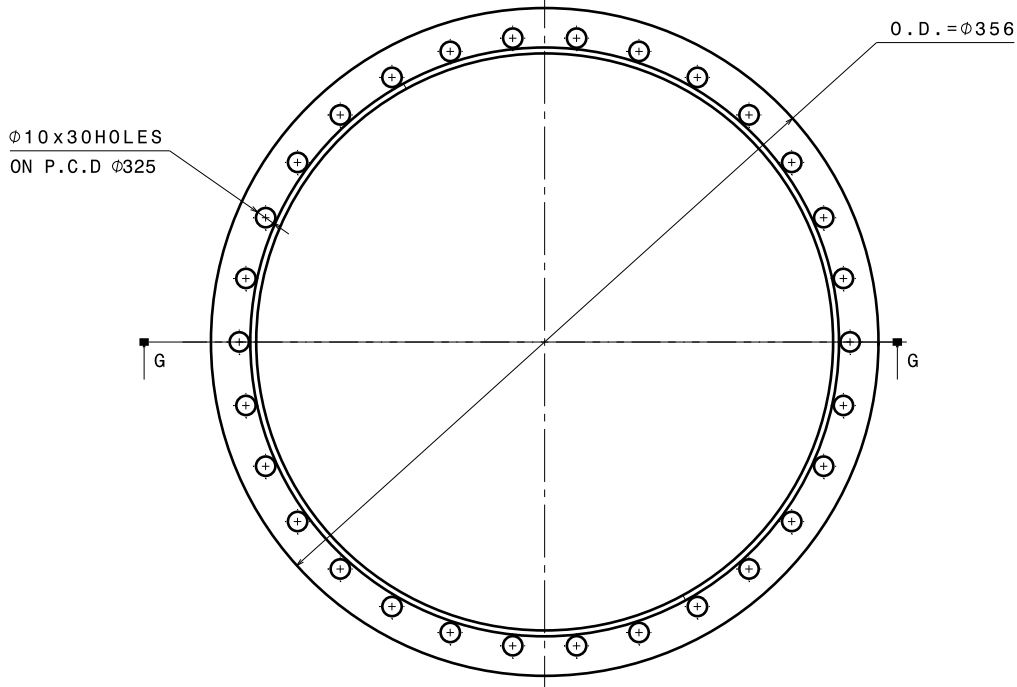


SECTION E-E

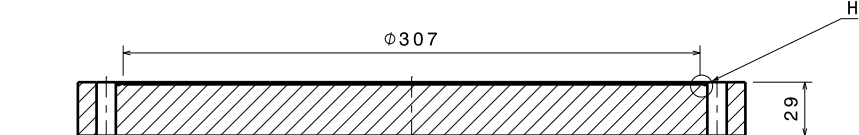
CUSTOM CF BLANK FLANGE (14")
SCALE-1:2



DETAIL VIEW-F
SCALE-3:1

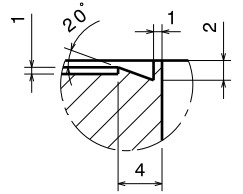


FRONT VIEW

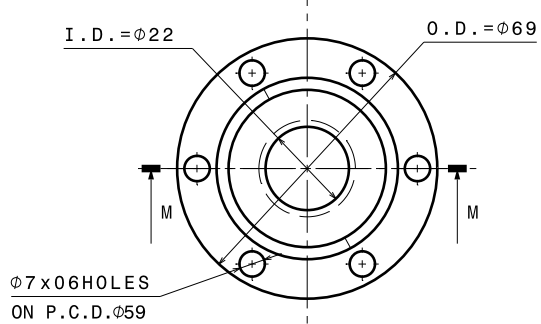


SECTION G-G

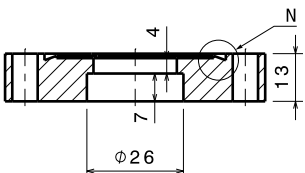
CUSTOM CF COVER FLANGE (14")
SCALE-1:2



DETAIL VIEW-H
SCALE-3:1

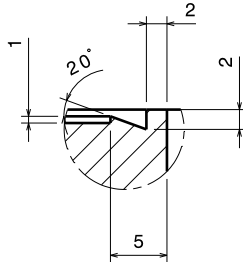


FRONT VIEW

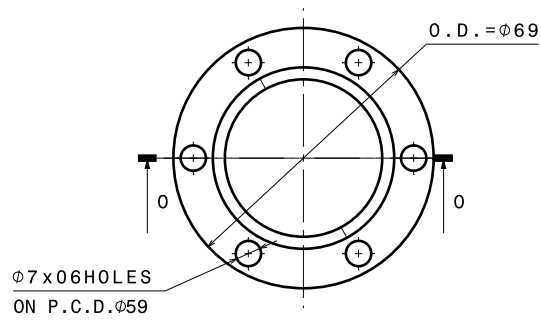


SECTION M-M

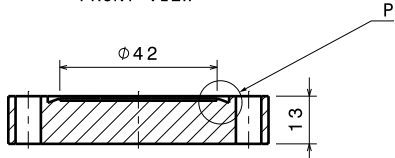
DN 40CF BLANK FLANGE
SCALE-1:1



DETAIL VIEW-N
SCALE-3:1

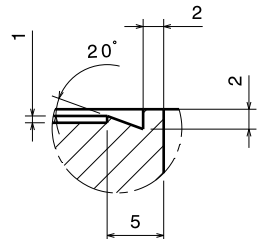


FRONT VIEW



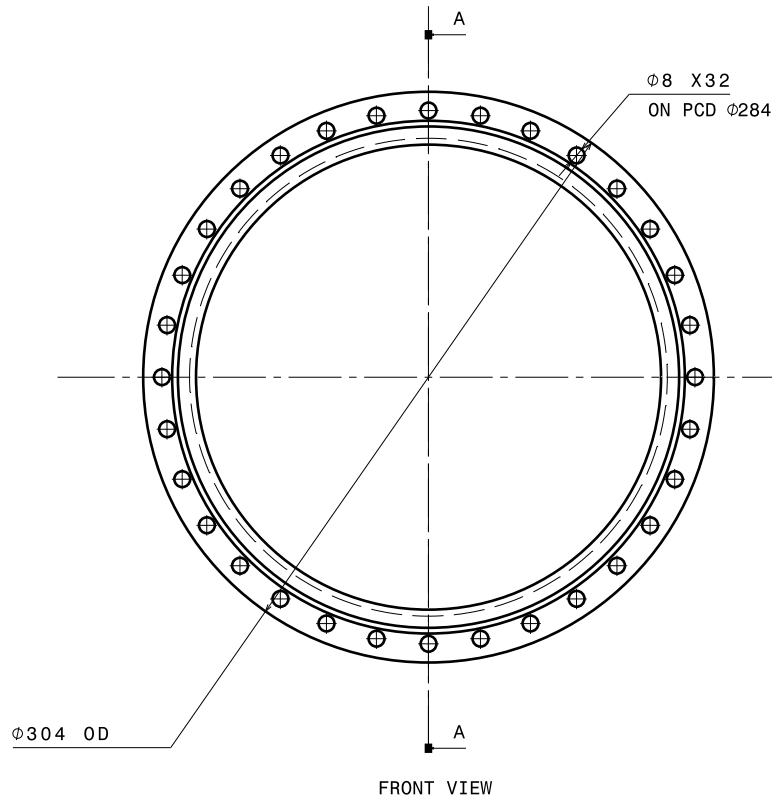
SECTION O-O

DN 40CF COVER FLANGE
SCALE-1:1

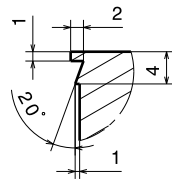
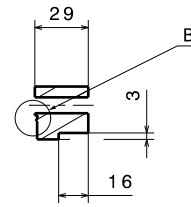


DETAIL VIEW-P
SCALE-3:1

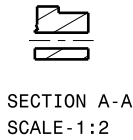
MATERIAL:	8-25	1.6-8	0.025-1.6	< 0.025	REVISION COLUMN						MED	SIZE A1	INSTITUTE FOR PLASMA RESEARCH (LIGO-INDIA) BHAT, GANDHINAGAR-382 428.		
CO-ORDINATED BY					REV	ZONE	DESCRIPTION	DATE	REMARKS	APPROVED BY	ALL DIMENSIONS ARE IN MM UNLESS OTHERWISE STATED	SCALE	AS NOTED	DATE	TITLE
MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS												DRAWN	A.N.N.	04/06/2014	STANDARD FLANGES
LENGTH IN mm OF SHORTER SIDE OF ANGLES				LENGTH OR DIA	UPTO 6	6-30	30-120	120-315				CHECKED	R.K.		REF DRG NO: NA
UPTO 10	10-50	50-120	OVER 120-400		+0.1	+0.2	+0.3	+0.5				APPROVED	M.K.G.		REV R0
+1°	+0°-30°	+0°-20°	+0°-10°											DRG.NO V001-001-R0	SHEET 02 OF 05



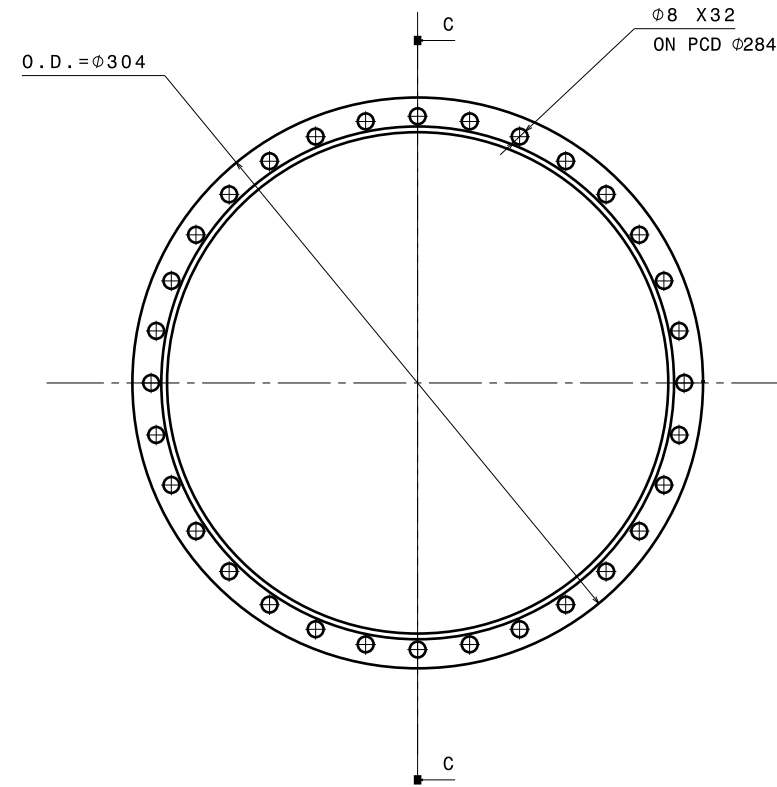
DN 250CF BLANK FLANGE
SCALE-1:2



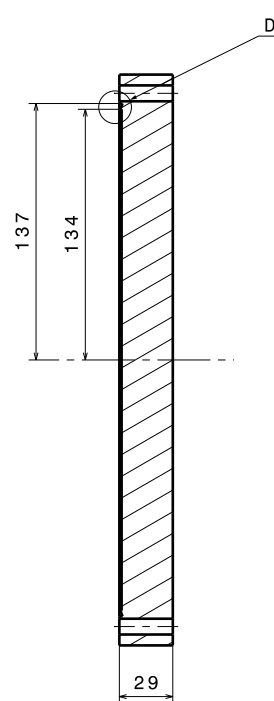
DETAIL VIEW-B
SCALE-2:1



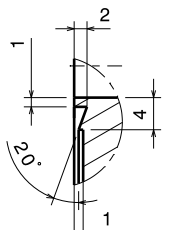
SECTION A-A
SCALE-1:2



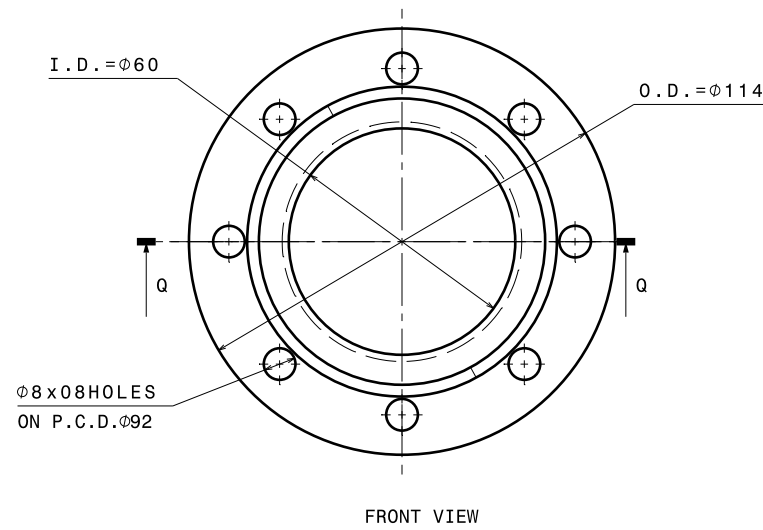
DN 250CF COVER FLANGE
SCALE-1:2



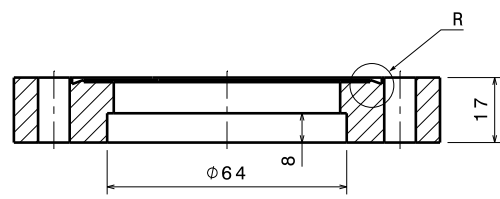
SECTION C-C



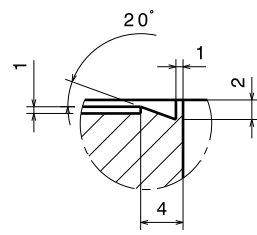
DETAIL VIEW-D
SCALE-2:1



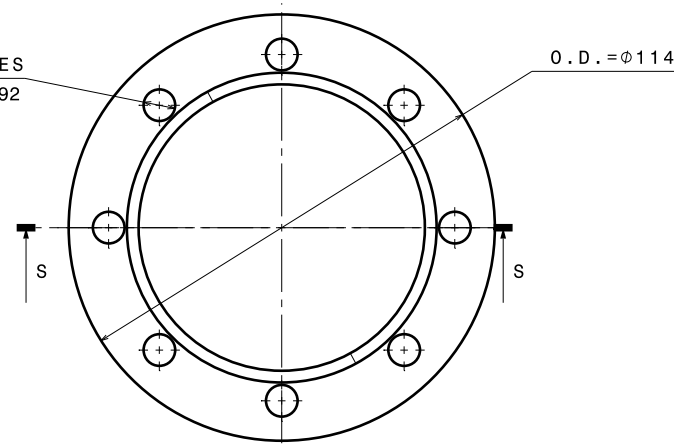
DN 63CF BLANK FLANGE
SCALE-1:1



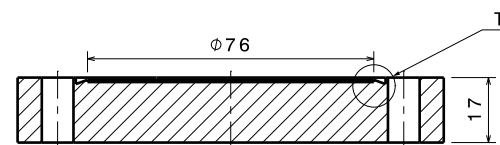
SECTION Q-Q



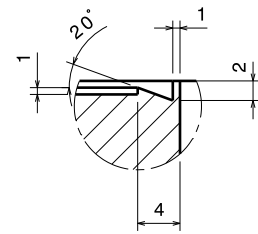
DETAIL VIEW-R
SCALE-3:1



DN 63CF COVER FLANGE
SCALE-1:1

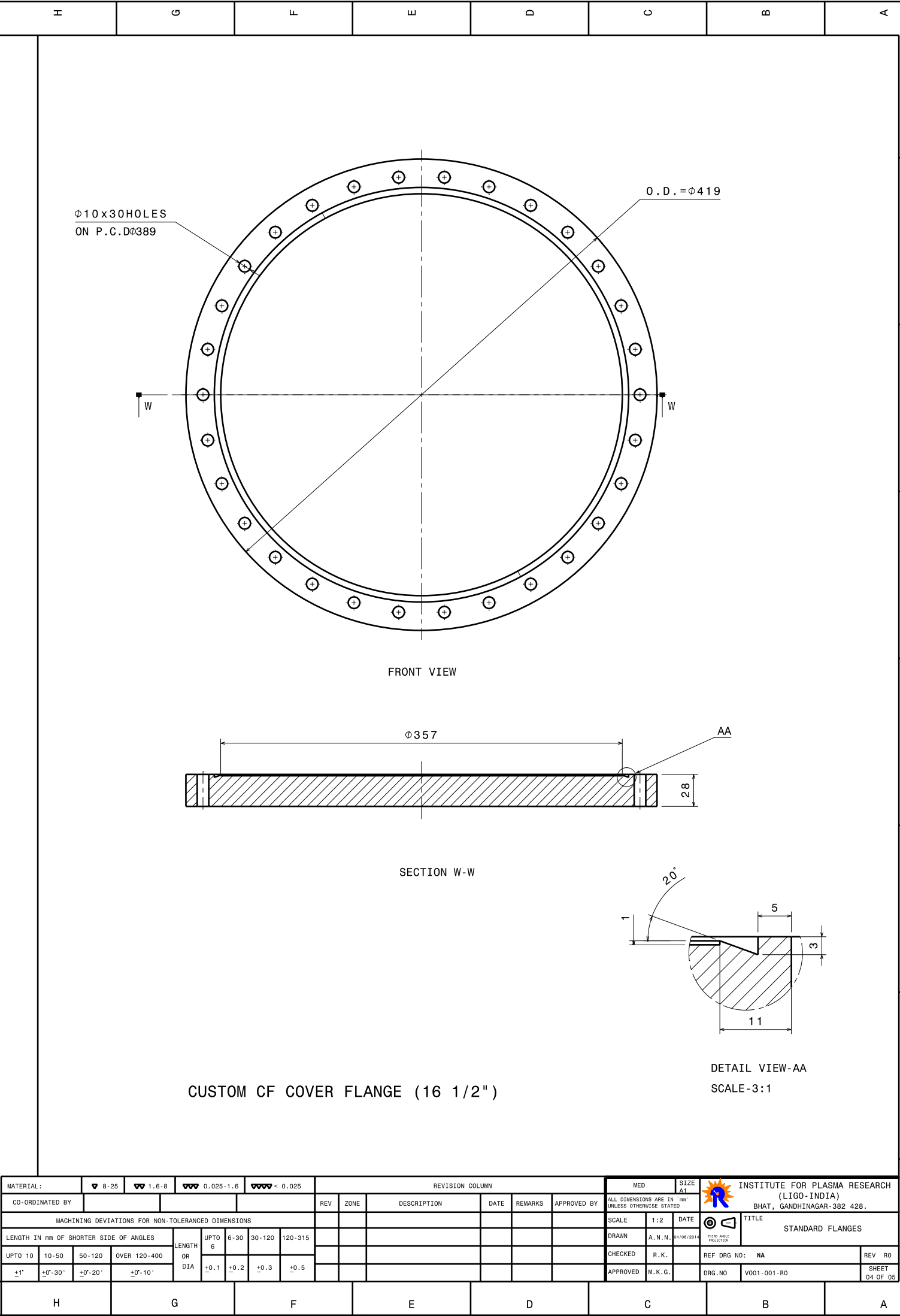
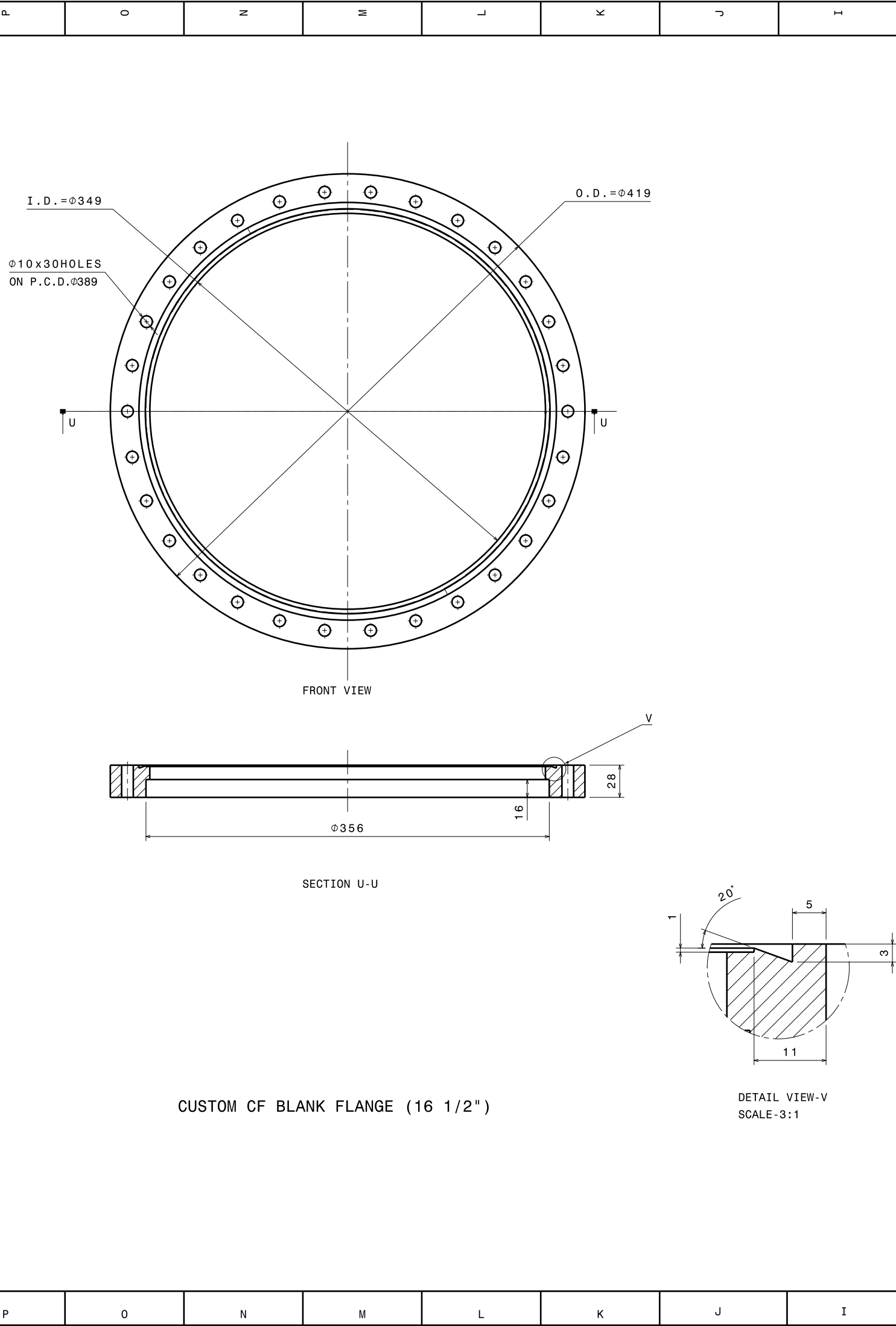


SECTION S-S

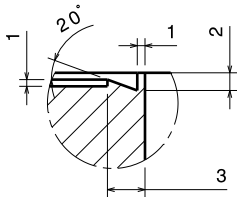
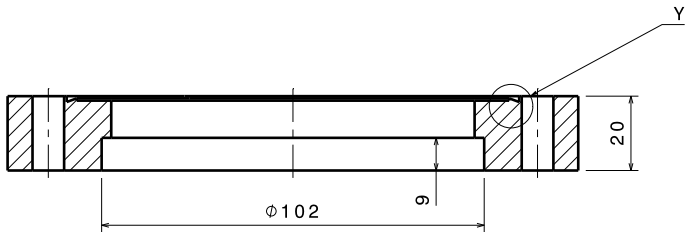
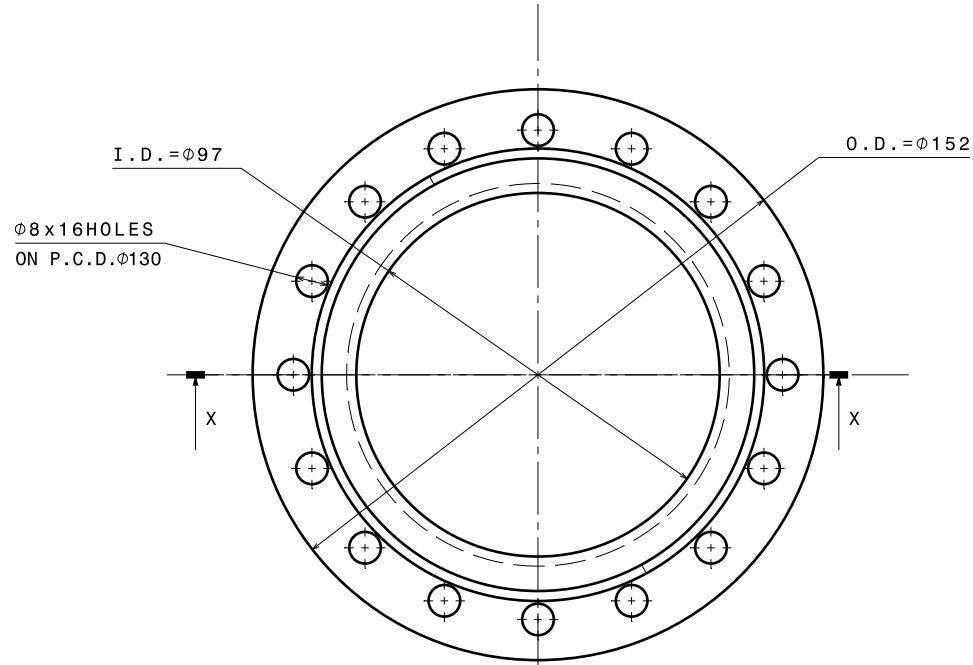


DETAIL VIEW-T
SCALE-3:1

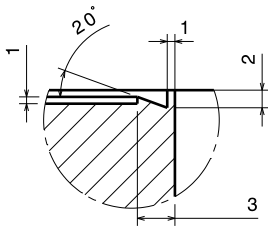
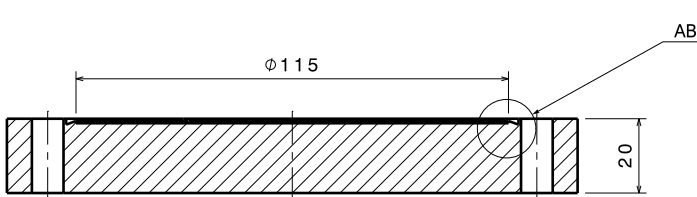
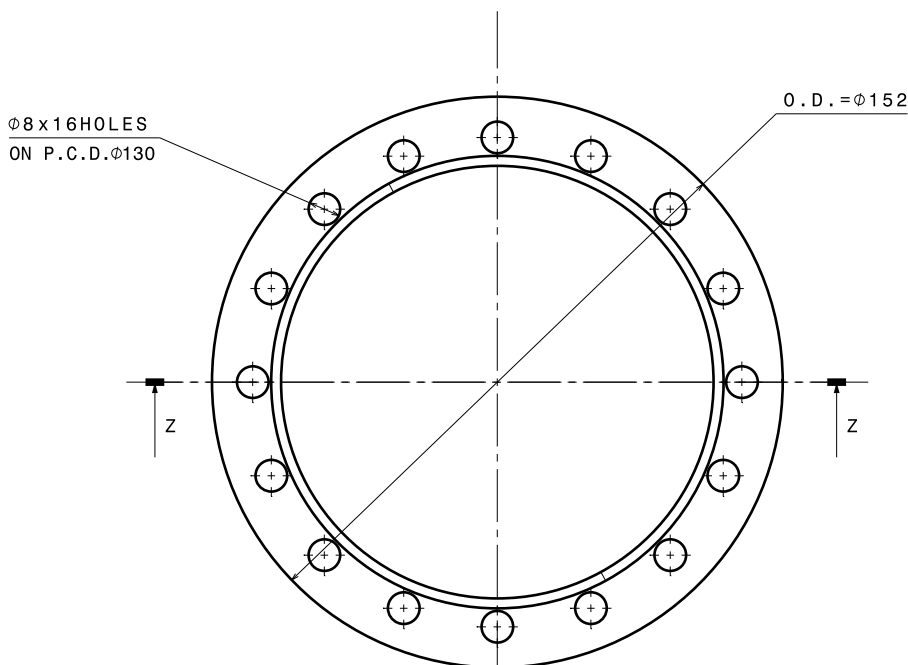
MATERIAL:				♥ 8-25				♥♥ 1.6-8				♥♥♥ 0.025-1.6				♥♥♥♥ < 0.025				REVISION COLUMN							MED		SIZE A1		 INSTITUTE FOR PLASMA RESEARCH (LIGO-INDIA) BHAT, GANDHINAGAR-382 428.												
CO-ORDINATED BY																REV		ZONE		DESCRIPTION		DATE		REMARKS		APPROVED BY		ALL DIMENSIONS ARE IN mm UNLESS OTHERWISE STATED															
MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS																														SCALE		AS NOTED		DATE		 TITLE STANDARD FLANGES							
LENGTH IN mm OF SHORTER SIDE OF ANGLES										LENGTH OR DIA		UPTO 6		6-30		30-120		120-315										DRAWN		A.N.N.		04/06/2014											
UPTO 10												10-50		50-120		OVER 120-400														CHECKED		R.K.				REF DRG NO: NA		REV RO					
±1°												±0°-30°		±0°-20°		±0°-10°		±0.1		±0.2		±0.3		±0.5										APPROVED		M.K.G.		DRG.NO		V001-001-RO		SHEET 03 OF 05	



MATERIAL:				REVISION COLUMN				MED	SIZE	INSTITUTE FOR PLASMA RESEARCH (LIGO-INDIA) BHAT, GANDHINAGAR-382 428.			
CO-ORDINATED BY				REV	ZONE	DESCRIPTION	DATE	REMARKS	APPROVED BY				
MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS										TITLE			
LENGTH IN mm OF SHORTER SIDE OF ANGLES										STANDARD FLANGES			
UPTO 10										REF DRG NO: NA			
±1°										SHEET 04 OF 05			

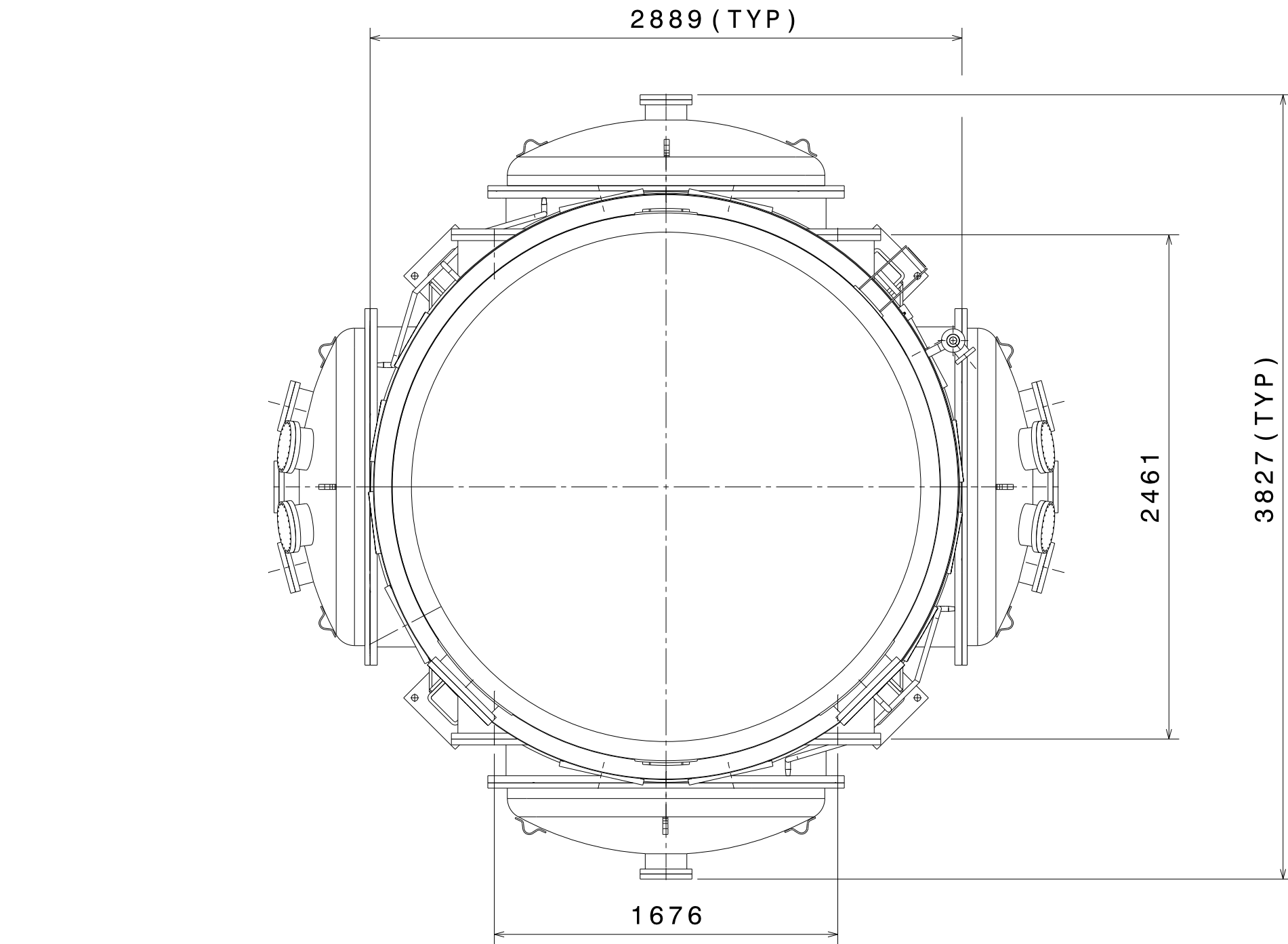


DN 100CF BLANK FLANGE

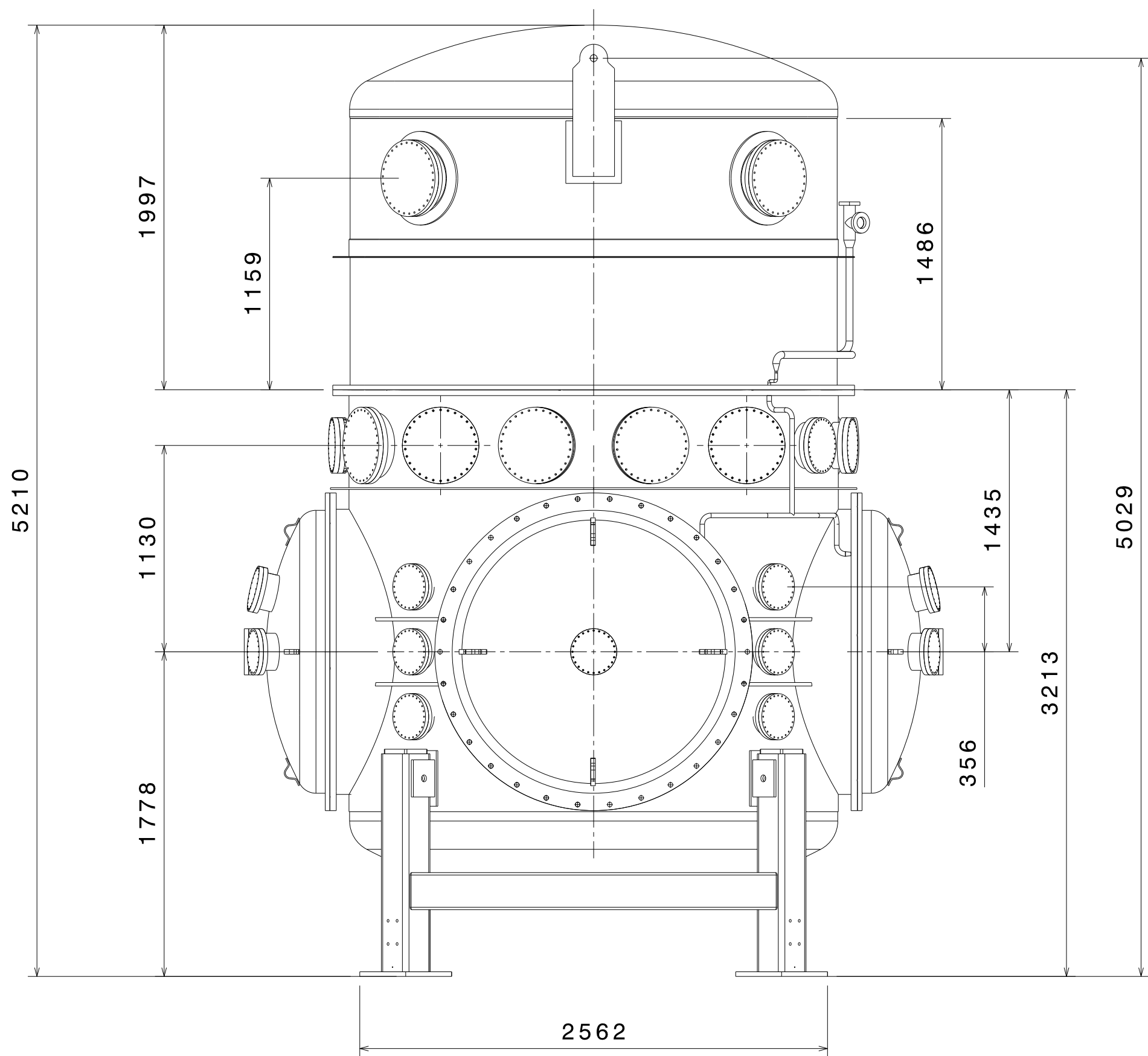


DN 100CF COVER FLANGE

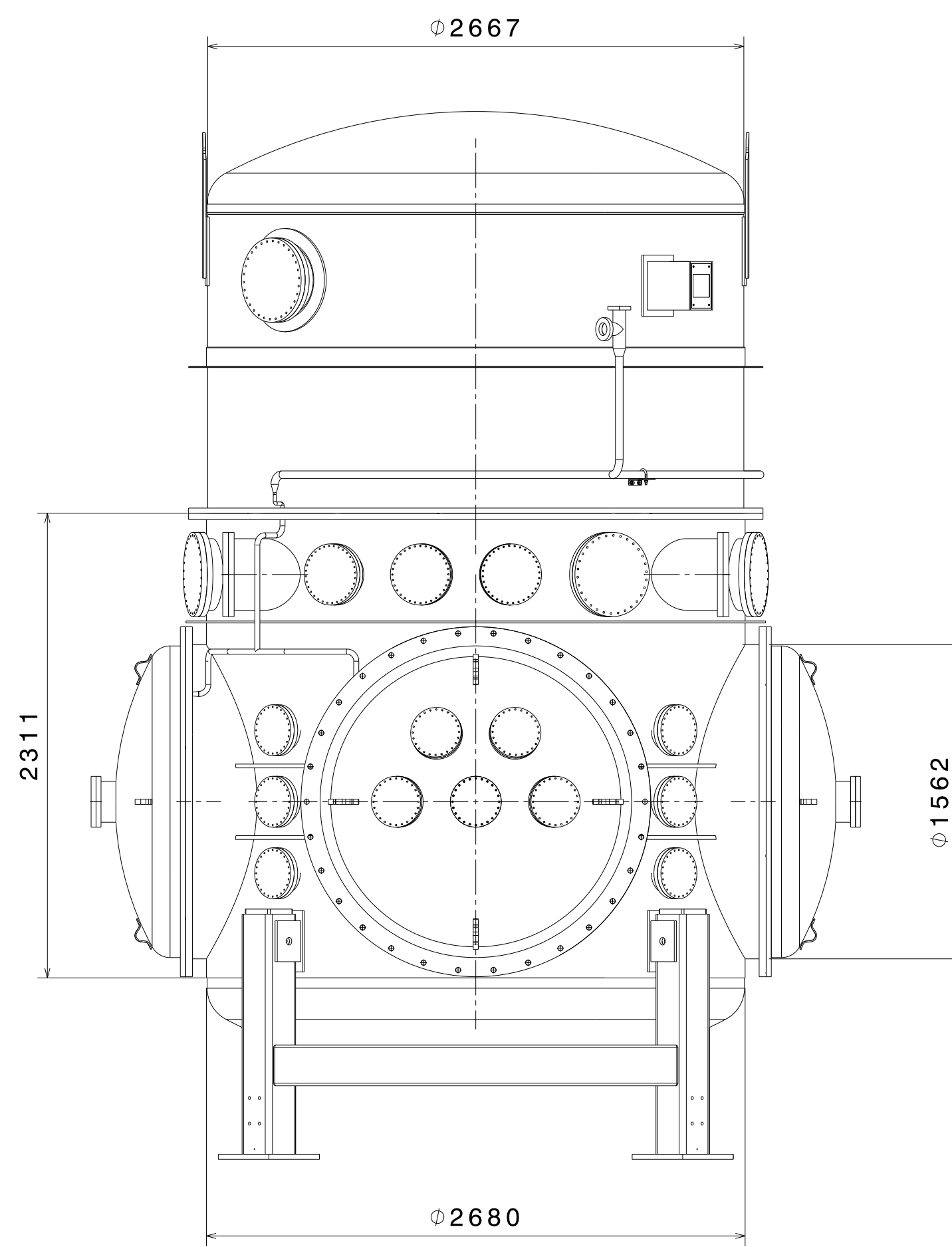
MATERIAL:				 8-25	 1.6-8	 0.025-1.6	 < 0.025	REVISION COLUMN					MED		SIZE A1			INSTITUTE FOR PLASMA RESEARCH (LIGO-INDIA) BHAT, GANDHINAGAR-382 428.	
CO-ORDINATED BY								REV	ZONE	DESCRIPTION	DATE	REMARKS	APPROVED BY	ALL DIMENSIONS ARE IN "mm" UNLESS OTHERWISE STATED					
MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS														SCALE	1:1	DATE		TITLE	STANDARD FLANGES
LENGTH IN mm OF SHORTER SIDE OF ANGLES				LENGTH OR DIA	UPTO 6	6-30	30-120	120-315					DRAWN	A.N.N.	04/06/2014				
UPTO 10	10-50	50-120	OVER 120-400		+0.1	+0.2	+0.3	+0.5						CHECKED	R.K.		REF DRG NO: NA	REV R0	
±1°	±0°-30°	±0°-20°	±0°-10°											APPROVED	M.K.G.		DRG. NO V001-001-R0	SHEET 05 OF 05	



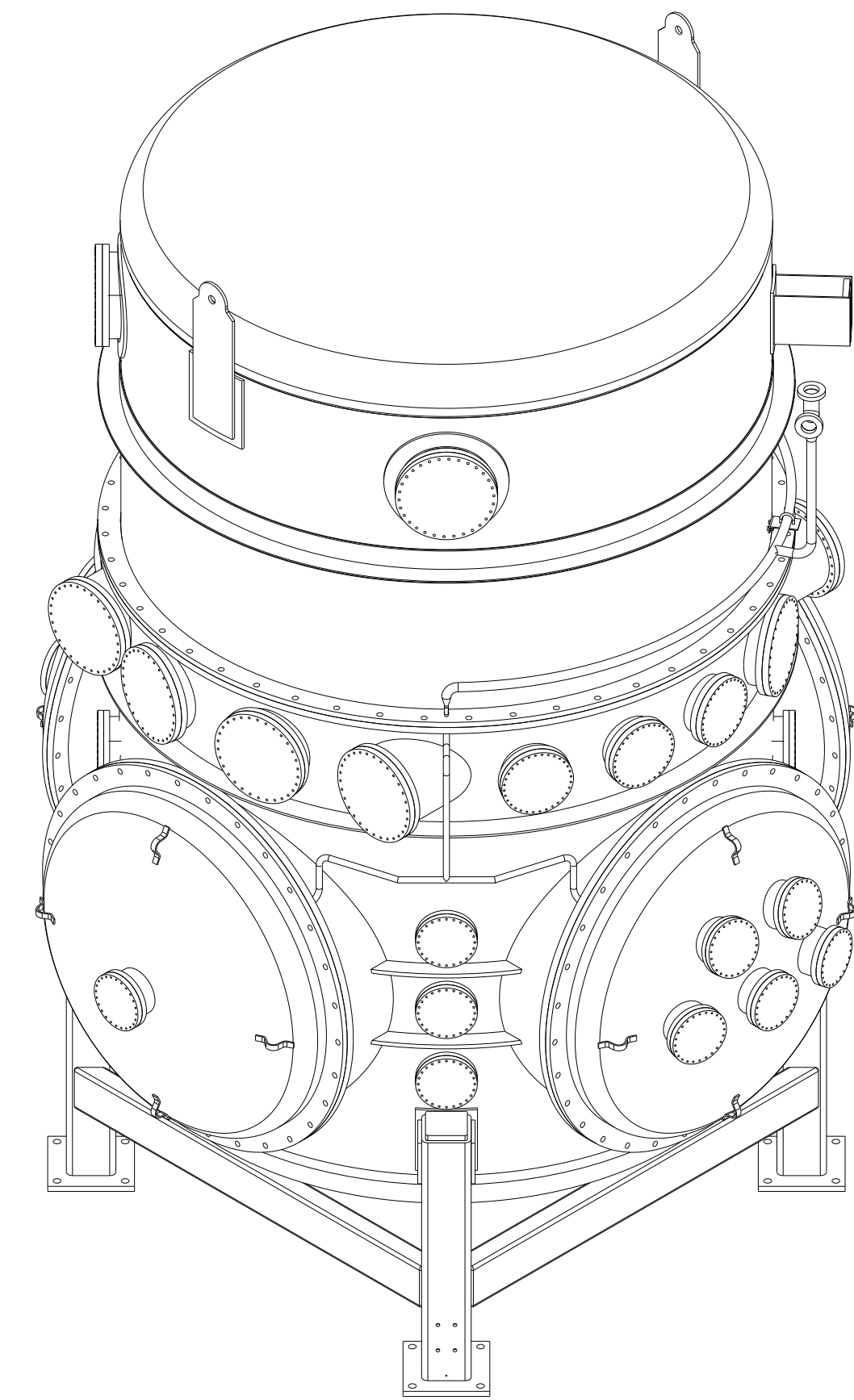
TOP VIEW



FRONT VIEW

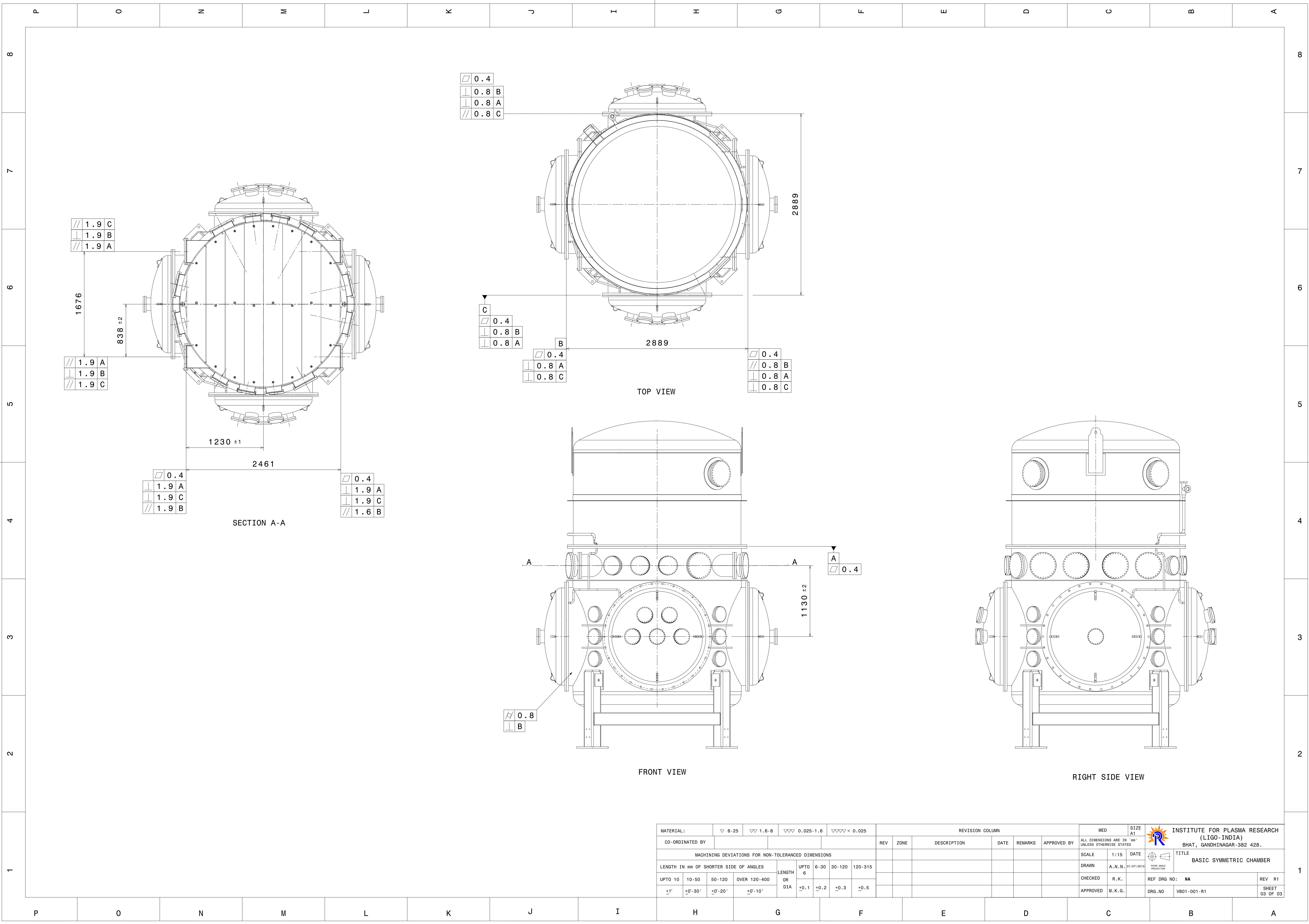


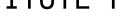
SIDE VIEW

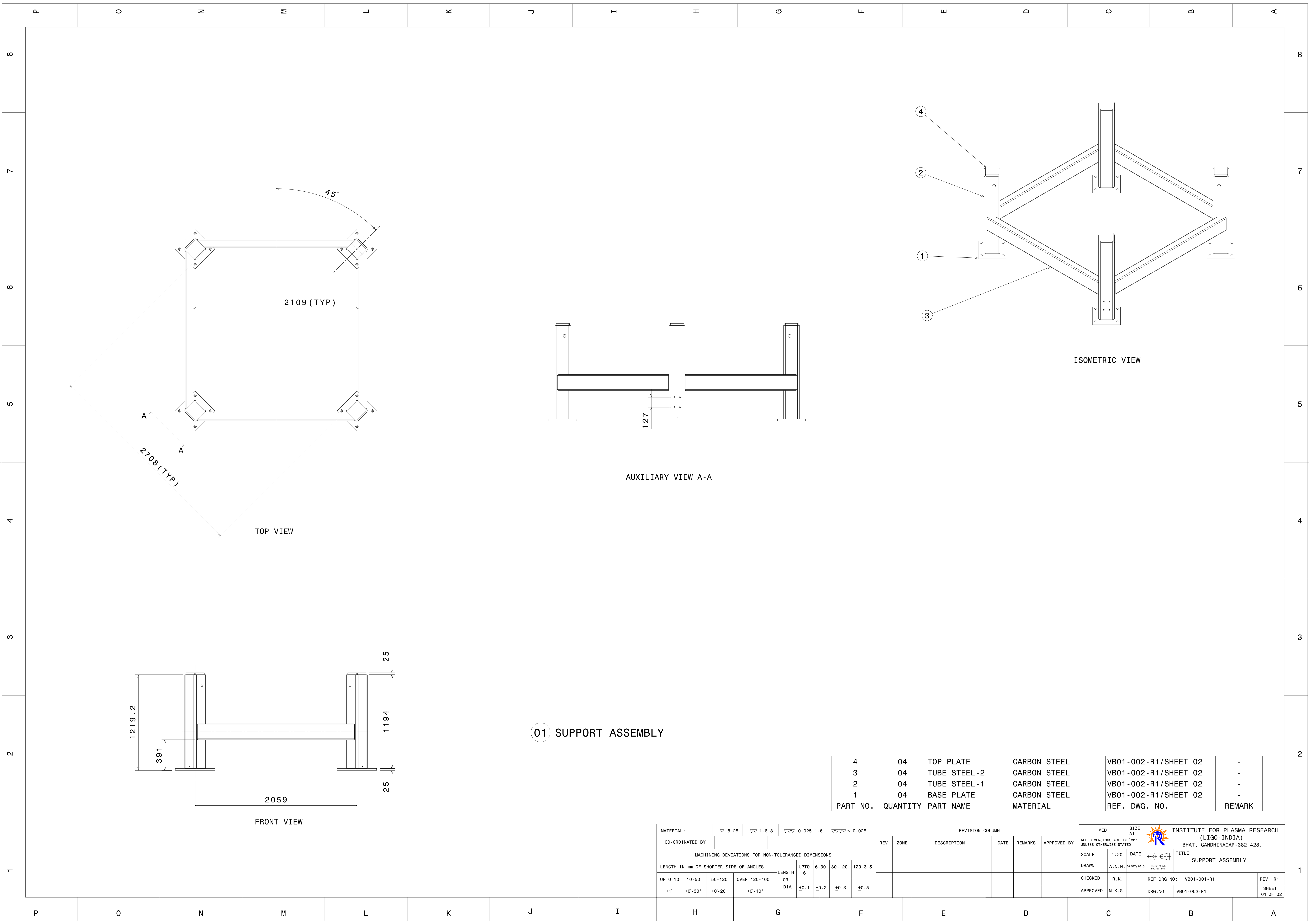


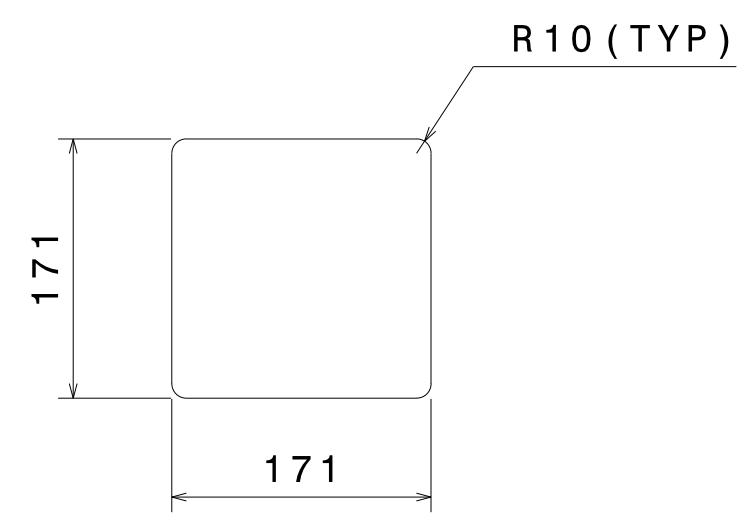
ISOMETRIC VIEW

MATERIAL:		▽ 8-25		▽▽ 1.6-8		▽▽▽ 0.025-1.6		▽▽▽▽ < 0.025		REVISION COLUMN						MED		SIZE A1	 INSTITUTE FOR PLASMA RESEARCH (LIGO - INDIA) BHAT, GANDHINAGAR-382 428.	
CO-ORDINATED BY										REV	ZONE	DESCRIPTION	DATE	REMARKS	APPROVED BY	ALL DIMENSIONS ARE IN "mm" UNLESS OTHERWISE STATED				
MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS																	SCALE	1:25	DATE	 TITLE BASIC SYMMETRIC CHAMBER
LENGTH IN mm OF SHORTER SIDE OF ANGLES						LENGTH OR DIA	UPTO 6	6-30	30-120	120-315						DRAWN	A.N.N.	01/07/2016		
UPTO 10							10-50	50-120	OVER 120-400							CHECKED	R. K.	REF DRG NO: NA	REV R1	
±1"							±0°-30'	±0°-20'	±0°-10'							APPROVED	M. K. G.	DRG. NO.	VB01-001-R1	

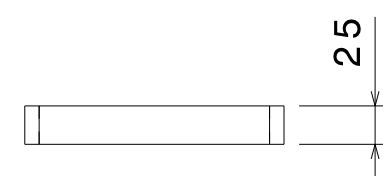


MATERIAL:		▽ 8-25	▽▽ 1.6-8	▽▽▽ 0.025-1.6	▽▽▽▽ < 0.025	REVISION COLUMN						MED	SIZE A1		INSTITUTE FOR PLASMA RESEARCH (LIGO-INDIA)		
CO-ORDINATED BY						REV	ZONE	DESCRIPTION	DATE	REMARKS	APPROVED BY	ALL DIMENSIONS ARE IN "mm" UNLESS OTHERWISE STATED	BHAT, GANDHINAGAR-382 428.				
MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS												SCALE	1:15	DATE		TITLE	
LENGTH IN mm OF SHORTER SIDE OF ANGLES				LENGTH OR DIA	UPTO 6	6-30	30-120	120-315				DRAWN	A.N.N.	01/07/2015		BASIC SYMMETRIC CHAMBER	
UPTO 10	10-50	50-120	OVER 120-400										CHECKED	R.K.	REF DRG NO: NA	REV R1	
±1'	±0°-30'	±0°-20'	±0°-10'		±0.1	±0.2	±0.3	±0.5					APPROVED	M.K.G.	DRG.NO	VB01-001-R1	SHEET 03 OF 03



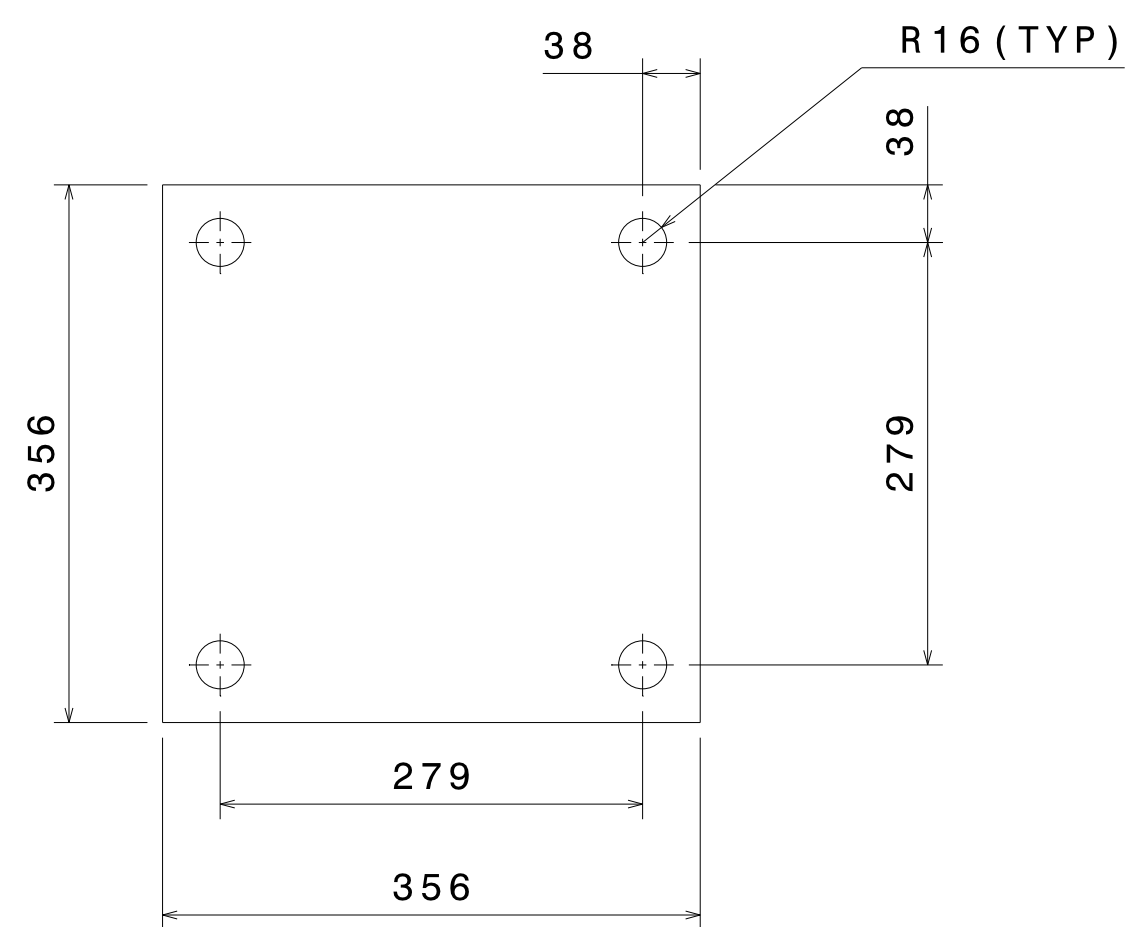


TOP VIEW

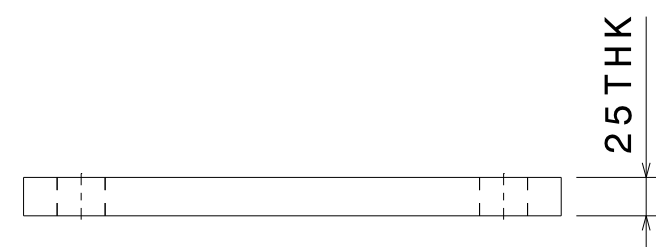


FRONT VIEW

④ TOP PLATE
SCALE - 1:5

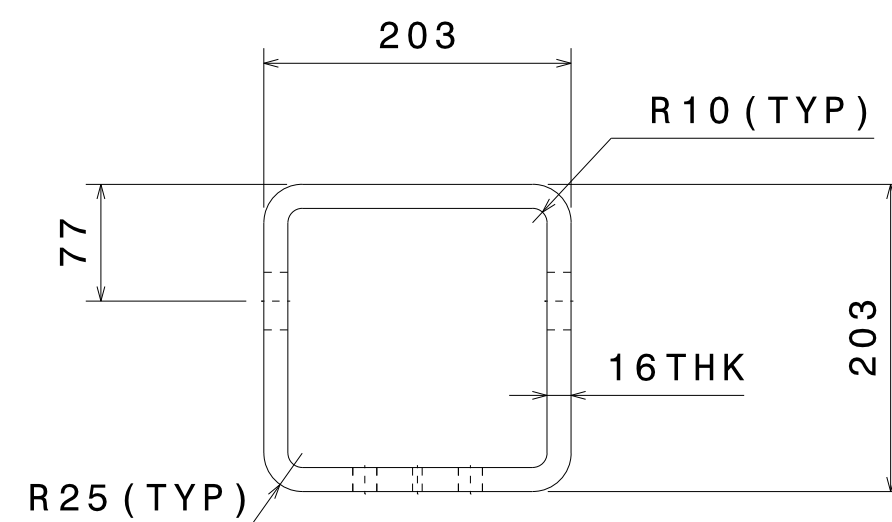


TOP VIEW

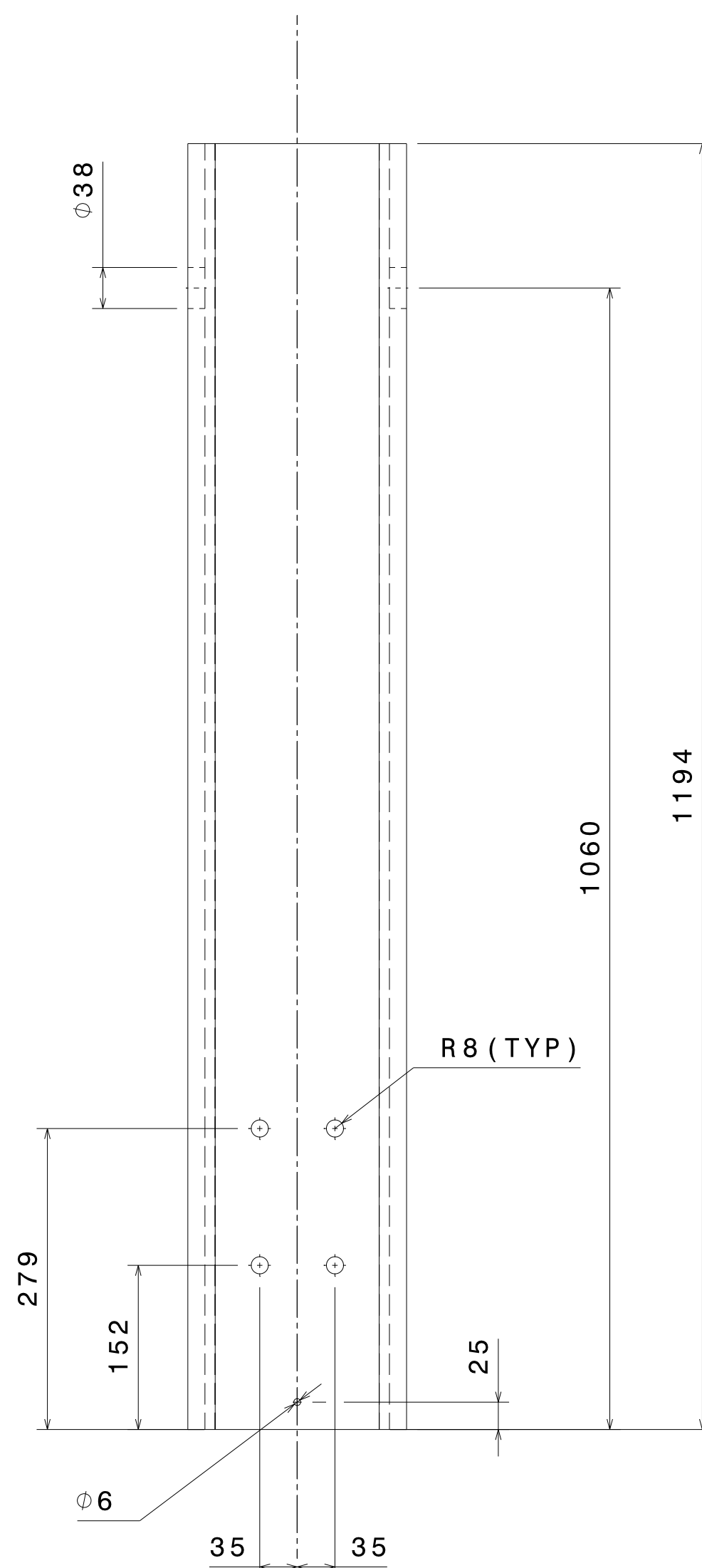


FRONT VIEW

① BASE PLATE
SCALE - 1:5

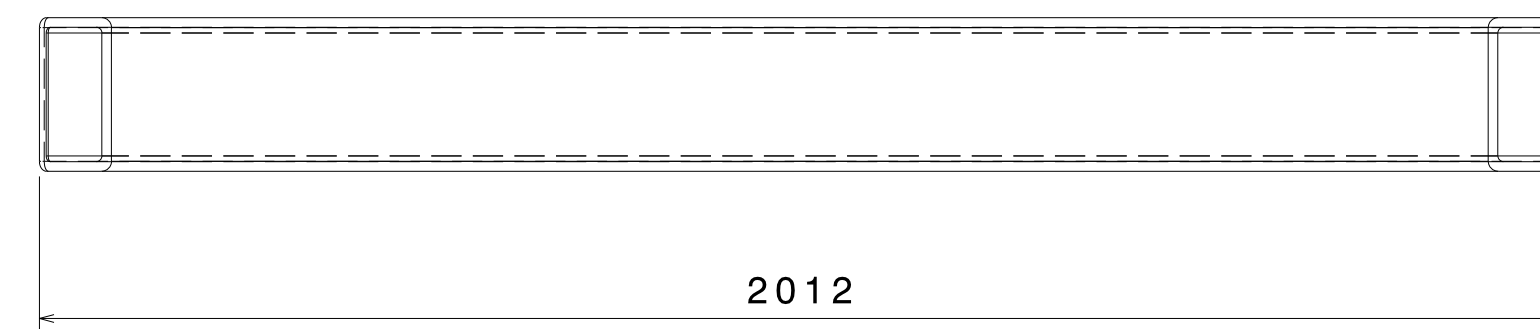


TOP VIEW

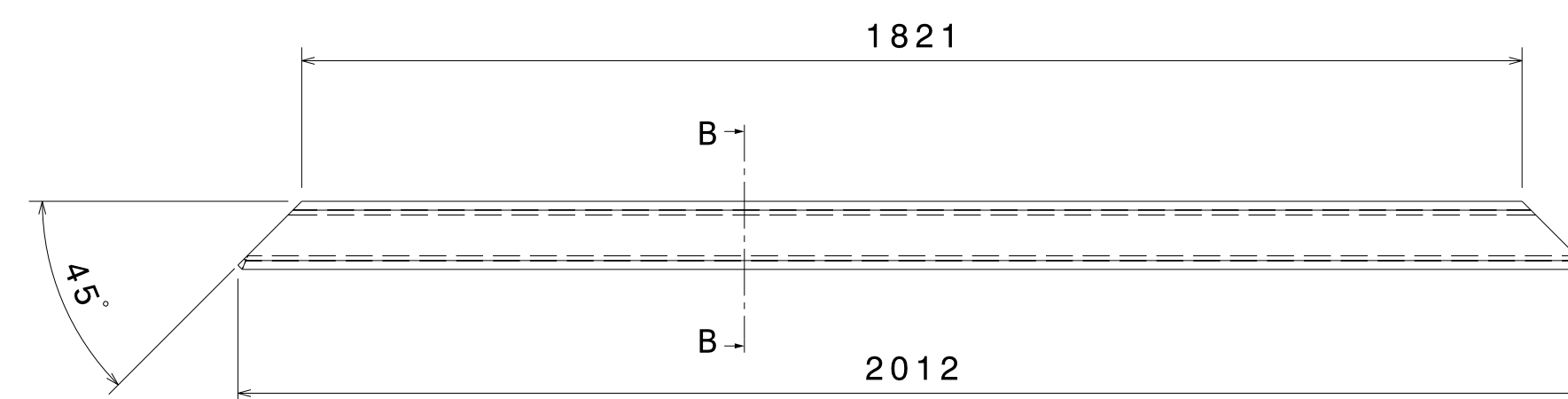


FRONT VIEW

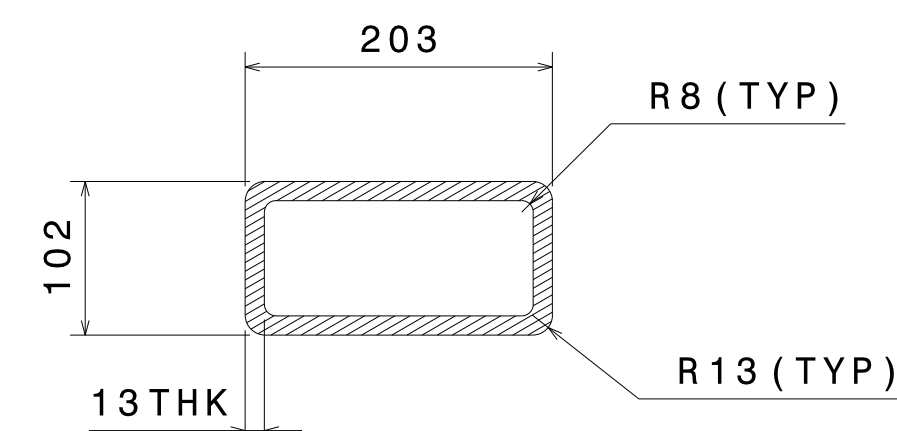
② TUBE STEEL - 1
SCALE - 1 : 5



TOP VIEW



FRONT VIEW



SECTION B-B
SCALE-1:5

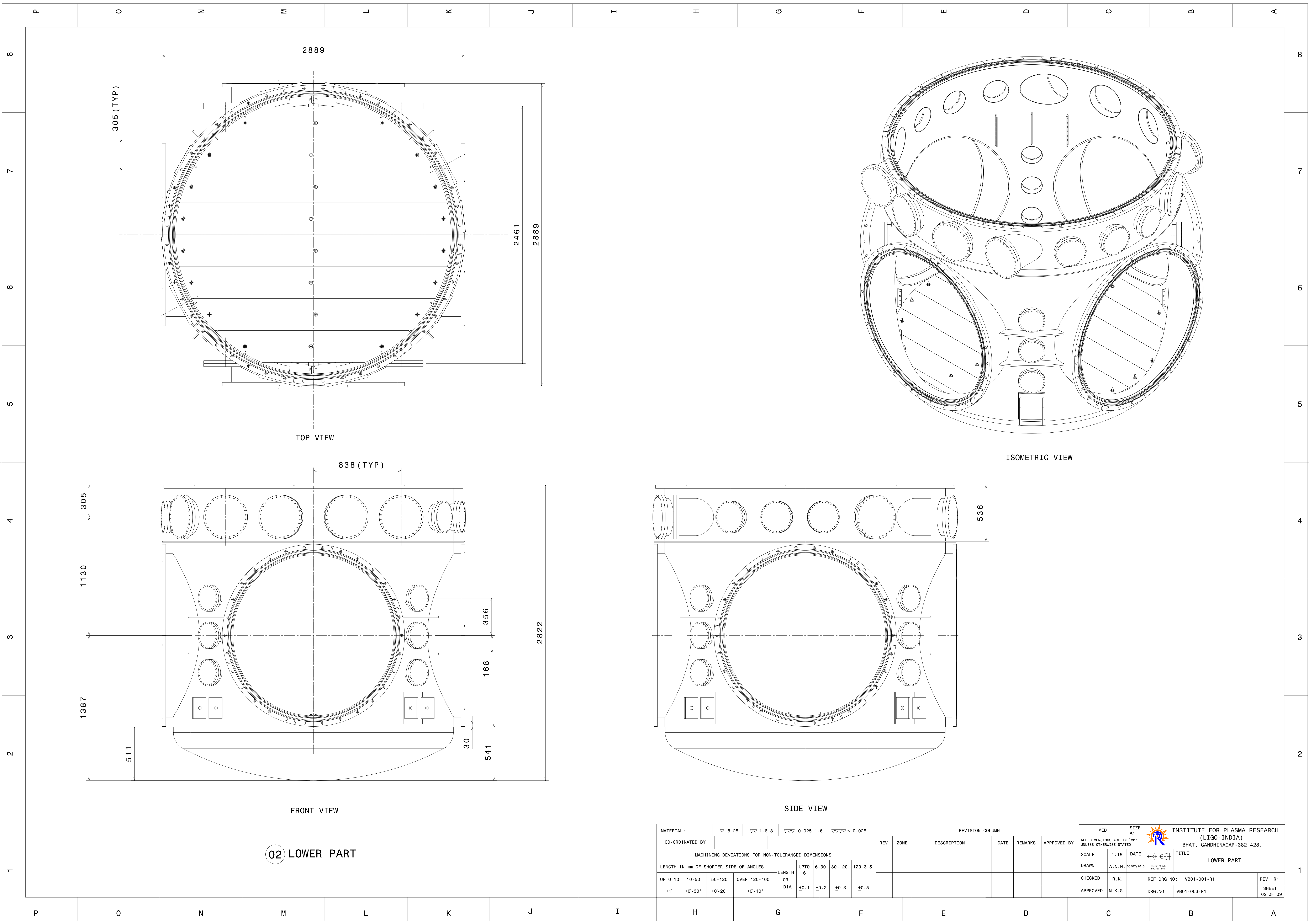
③ TUBE STEEL-2
SCALE-1:10

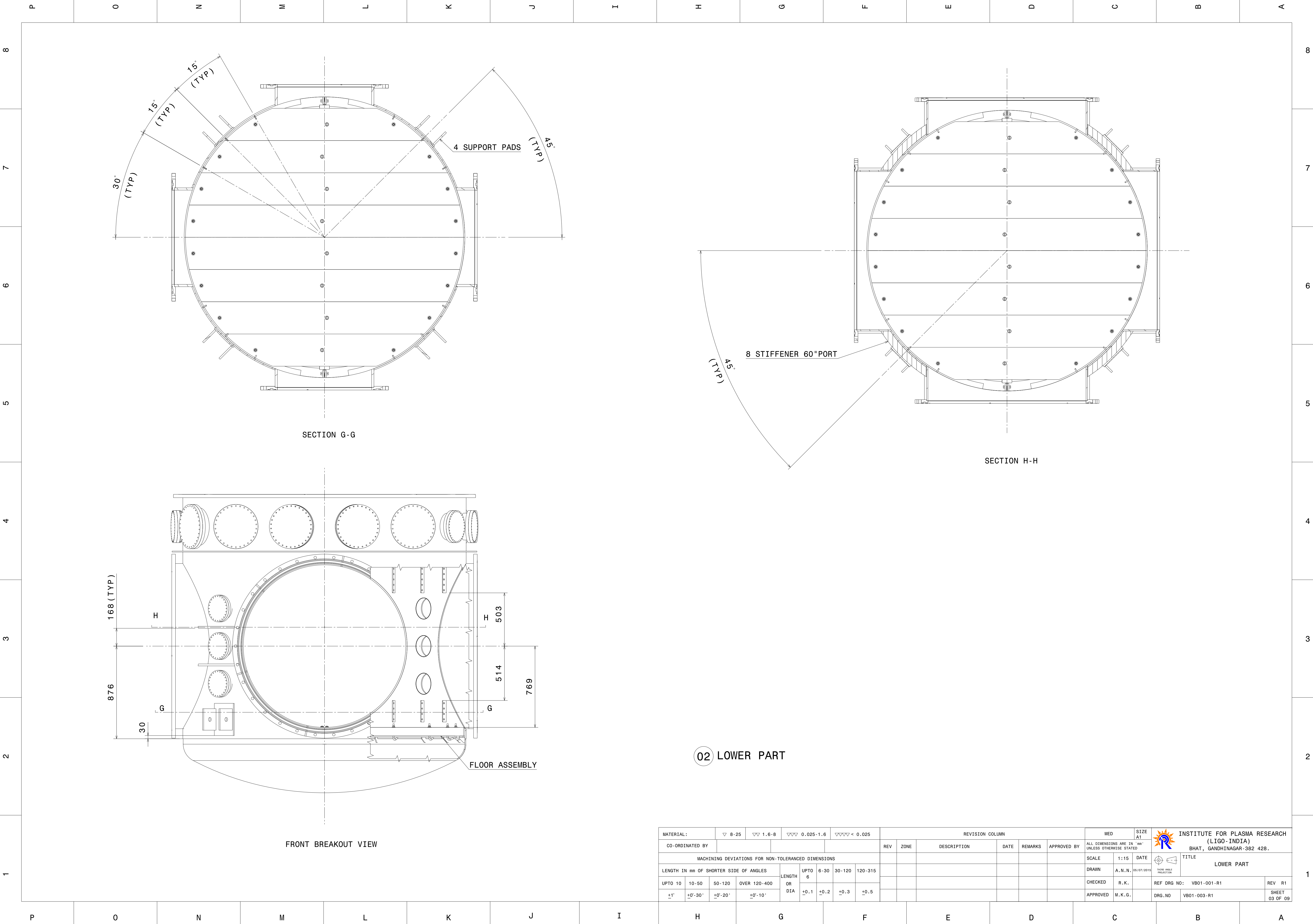
MATERIAL:				▽ 8-25		▽▽ 1.6-8		▽▽▽ 0.025-1.6		▽▽▽▽ < 0.025		REVISION COLUMN						MED		SIZE A1		 INSTITUTE FOR PLASMA RESEARCH (LIGO-INDIA) BHAT, GANDHINAGAR-382 428.							
CO-ORDINATED BY												REV		ZONE		DESCRIPTION		DATE		REMARKS				APPROVED BY		ALL DIMENSIONS ARE IN "mm" UNLESS OTHERWISE STATED			
MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS																						SCALE		AS NOTED		DATE		 TITLE SUPPORT ASSEMBLY	
LENGTH IN mm OF SHORTER SIDE OF ANGLES																								DRAWN		A. N. N.			
UPTO 10				10-50		50-120		OVER 120-400		LENGTH OR DIA		UPTO 6		6-30		30-120		120-315											
±1°				±0°-30'		±0°-20'		±0°-10'				±0.1		±0.2		±0.3		±0.5											
																										REF DRG NO: VB01-001-R1		REV R1	
																										REF DRG NO: VB01-002-R1		SHEET 02 OF 02	



PART NO.	QUANTITY	PART NAME	MATERIAL	REF. DWG. NO.	REMARK
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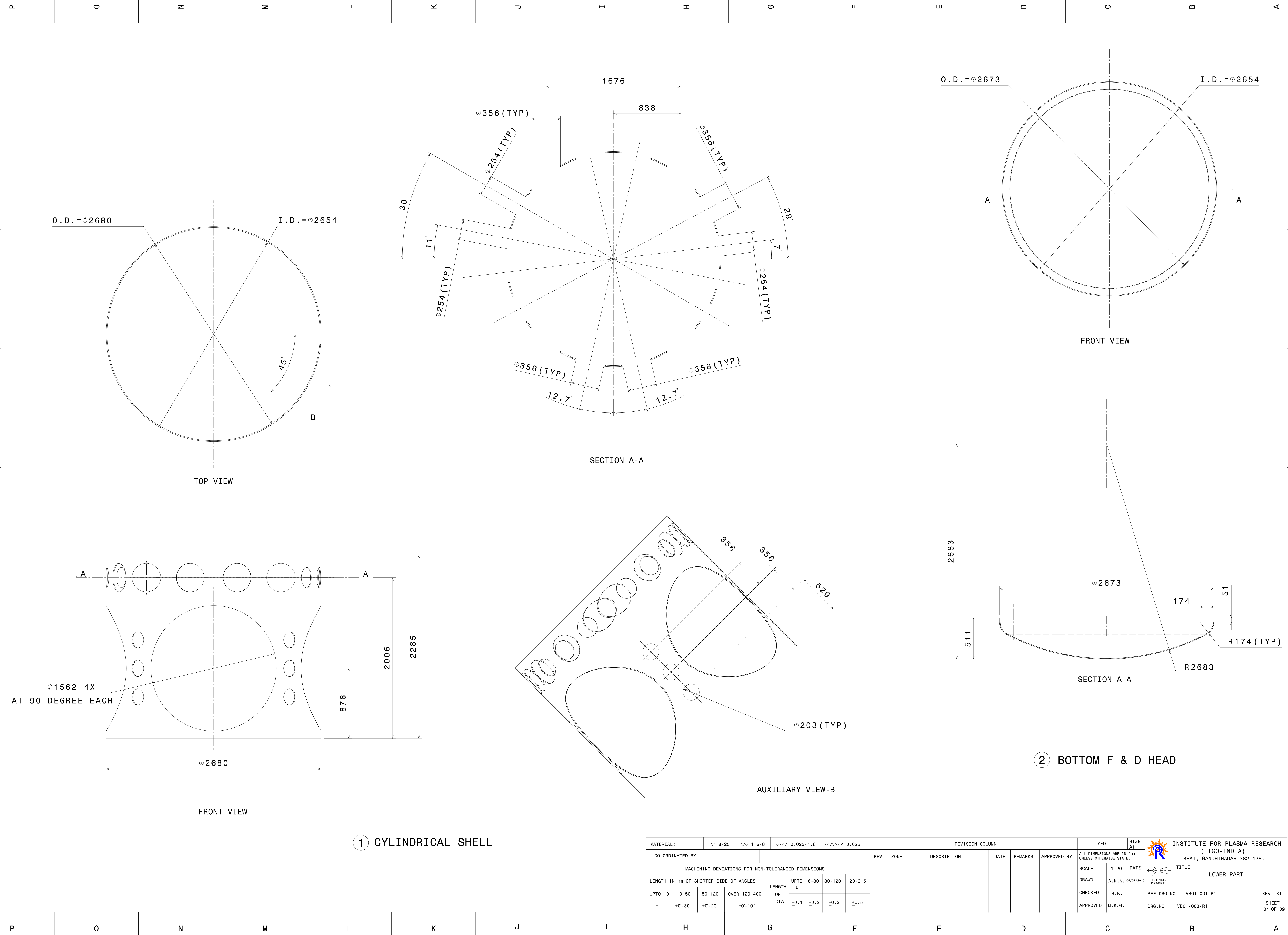
MATERIAL:				▽ 8-25	▽▽ 1.6-8	▽▽▽ 0.025-1.6	▽▽▽▽ < 0.025	REVISION COLUMN					MED		SIZE A1	 INSTITUTE FOR PLASMA RESEARCH (LIGO-INDIA) BHAT, GANDHINAGAR-382 428.			
CO-ORDINATED BY								REV	ZONE	DESCRIPTION		DATE	REMARKS	APPROVED BY	ALL DIMENSIONS ARE IN "mm" UNLESS OTHERWISE STATED.				
MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS																			
LENGTH IN mm OF SHORTER SIDE OF ANGLES				LENGTH OR DIA	UPTO 6	6-30	30-120	120-315						SCALE	1:15	DATE		TITLE	
DRAWN	A. N. N.	05/07/2015			LOWER PART														
CHECKED	R. K.		REF DRG NO:		VB01-001-R1	REV R1													
APPROVED	M. K. G.		DRG. NO		VB01-003-R1	SHEET 01 OF 09													
UPTO 10	10-50	50-120	OVER 120-400		+0.1	+0.2	+0.3	+0.5											
+1'	+0'-30'	+0'-20'	+0'-10'																





02 LOWER PART

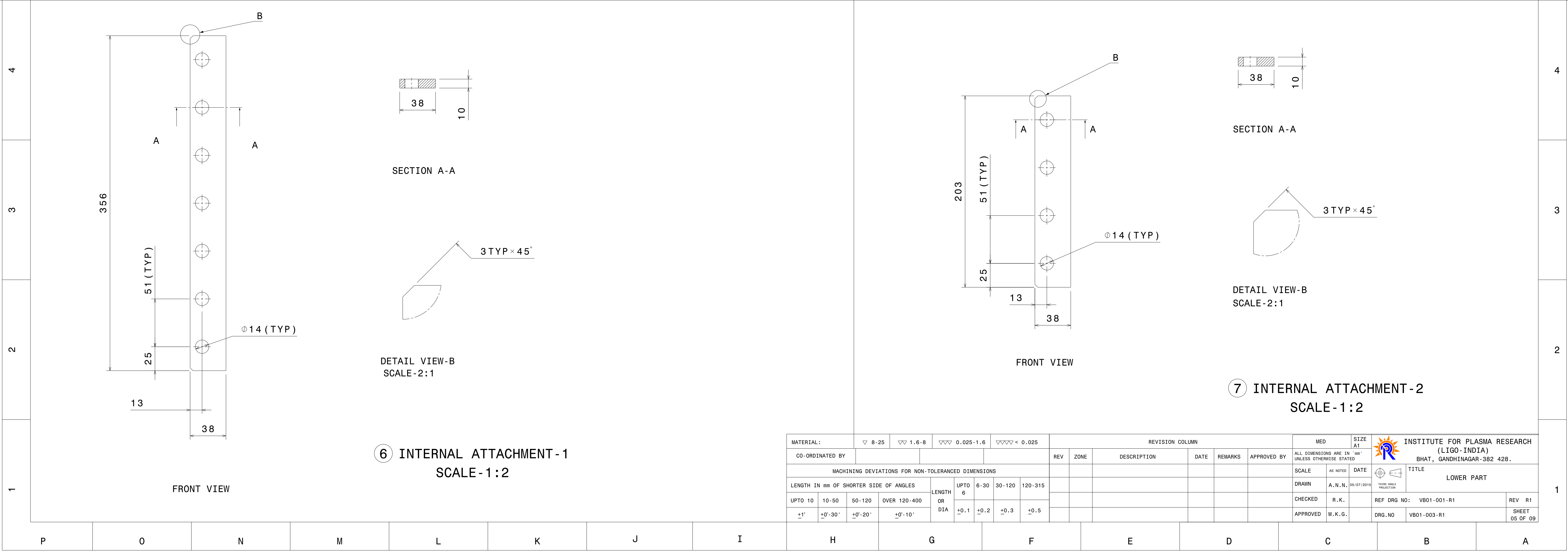
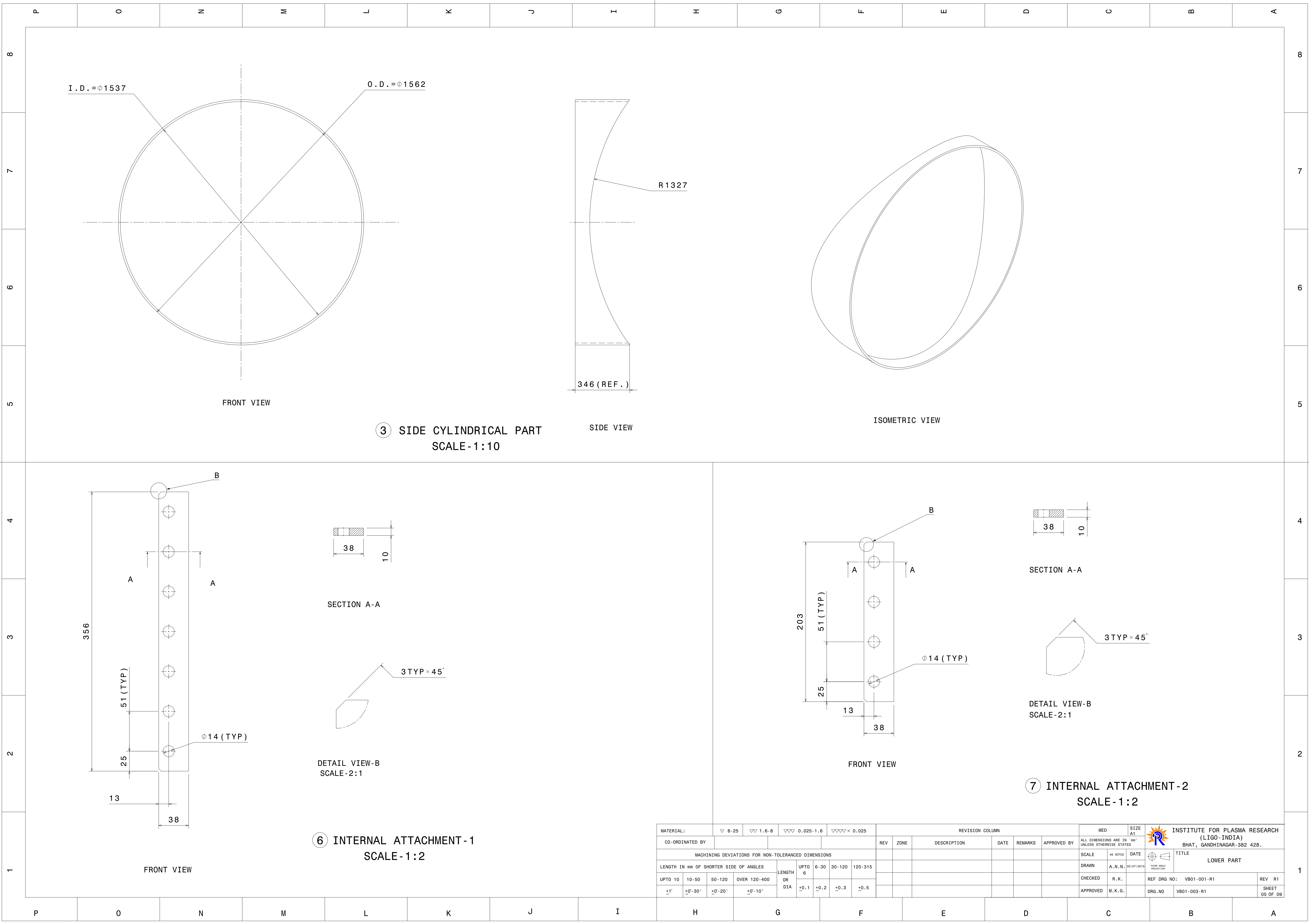
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CO-ORDINATED BY								REV	ZONE	DESCRIPTION	DATE	REMARKS	APPROVED BY	ALL DIMENSIONS ARE IN "mm" UNLESS OTHERWISE STATED				
MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS												SCALE	1:15	DATE		TITLE		
LENGTH IN mm OF SHORTER SIDE OF ANGLES				LENGTH OR DIA	UPTO 6	6-30	30-120	120-315			DRAWN	A.N.N.	05/07/2015	LOWER PART				
UPTO 10	10-50	50-120	OVER 120-400								CHECKED	R.K.		REF DRG NO:	VB01-001-R1		REV R1	
+1'	+0°-30'	+0°-20'	+0°-10'		+0.1	+0.2	+0.3	+0.5			APPROVED	M.K.G.		DRG.NO	VB01-003-R1		SHEET 03 OF 09	

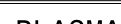


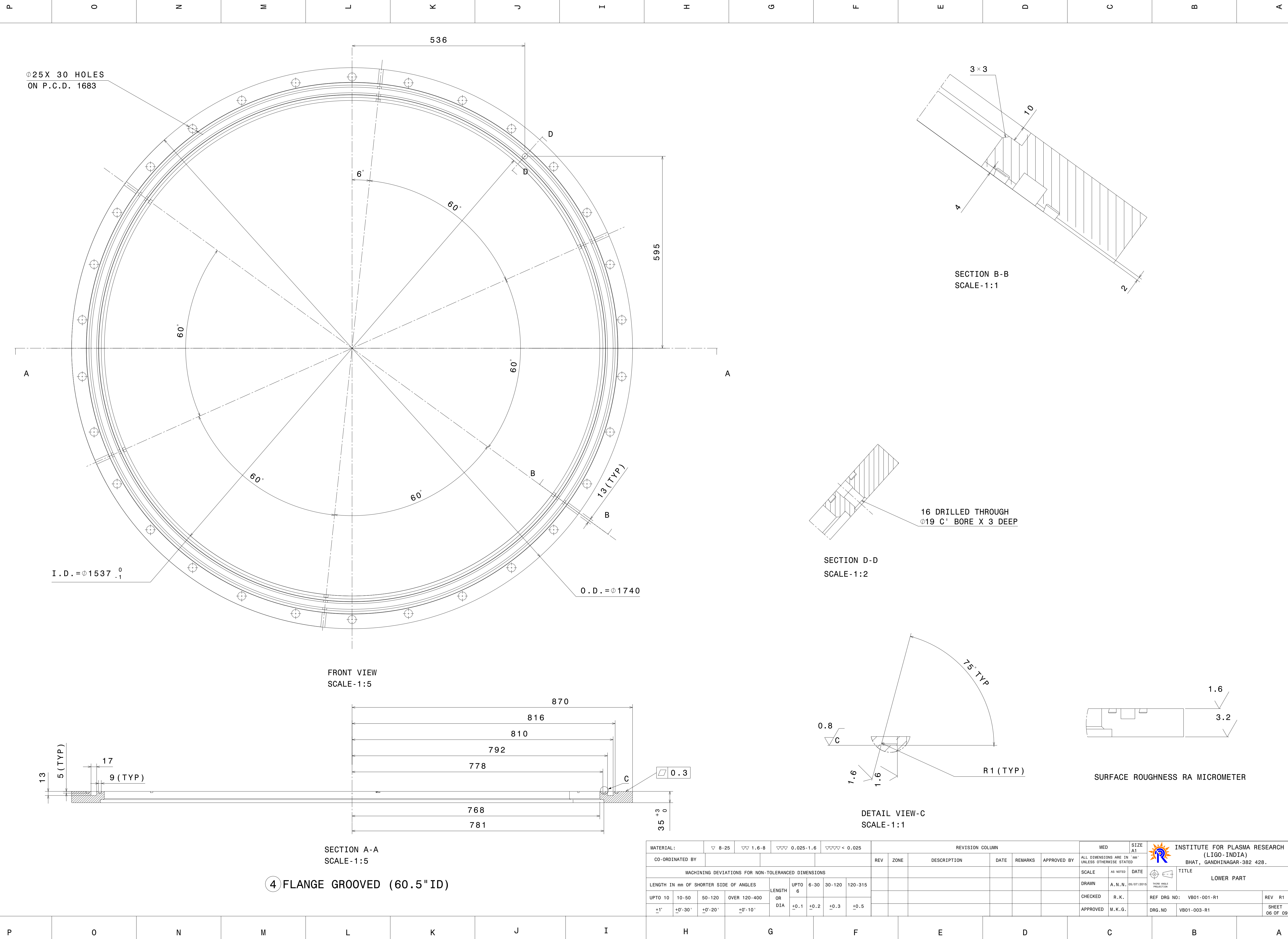
1 CYLINDRICAL SHELL

2 BOTTOM F & D HEAD

MATERIAL:		▽ 8-25		▽▽ 1.6-8		▽▽▽ 0.025-1.6		▽▽▽▽ < 0.025		REVISION COLUMN							MED		SIZE A1			INSTITUTE FOR PLASMA RESEARCH (LIGO-INDIA)												
CO-ORDINATED BY										REV	ZONE	DESCRIPTION			DATE	REMARKS		APPROVED BY		ALL DIMENSIONS ARE IN "mm" UNLESS OTHERWISE STATED				BHAT, GANDHINAGAR-382 428.										
MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS																								SCALE		1:20	DATE			TITLE				
LENGTH IN mm OF SHORTER SIDE OF ANGLES				LENGTH OR DIA	UPTO 6	6-30	30-120		120-315																DRAWN		A.N.N.	05/07/2016	LOWER PART					
UPTO 10	10-50	50-120		OVER 120-400																				CHECKED		R.K.		REF DRG NO:	VB01-001-R1		REV R1			
±1'	±0'-30'	±0'-20'		±0'-10'		+0.1	+0.2	+0.3		+0.5																APPROVED		M.K.G.		DRG.NO	VB01-003-R1		SHEET 04 OF 09	

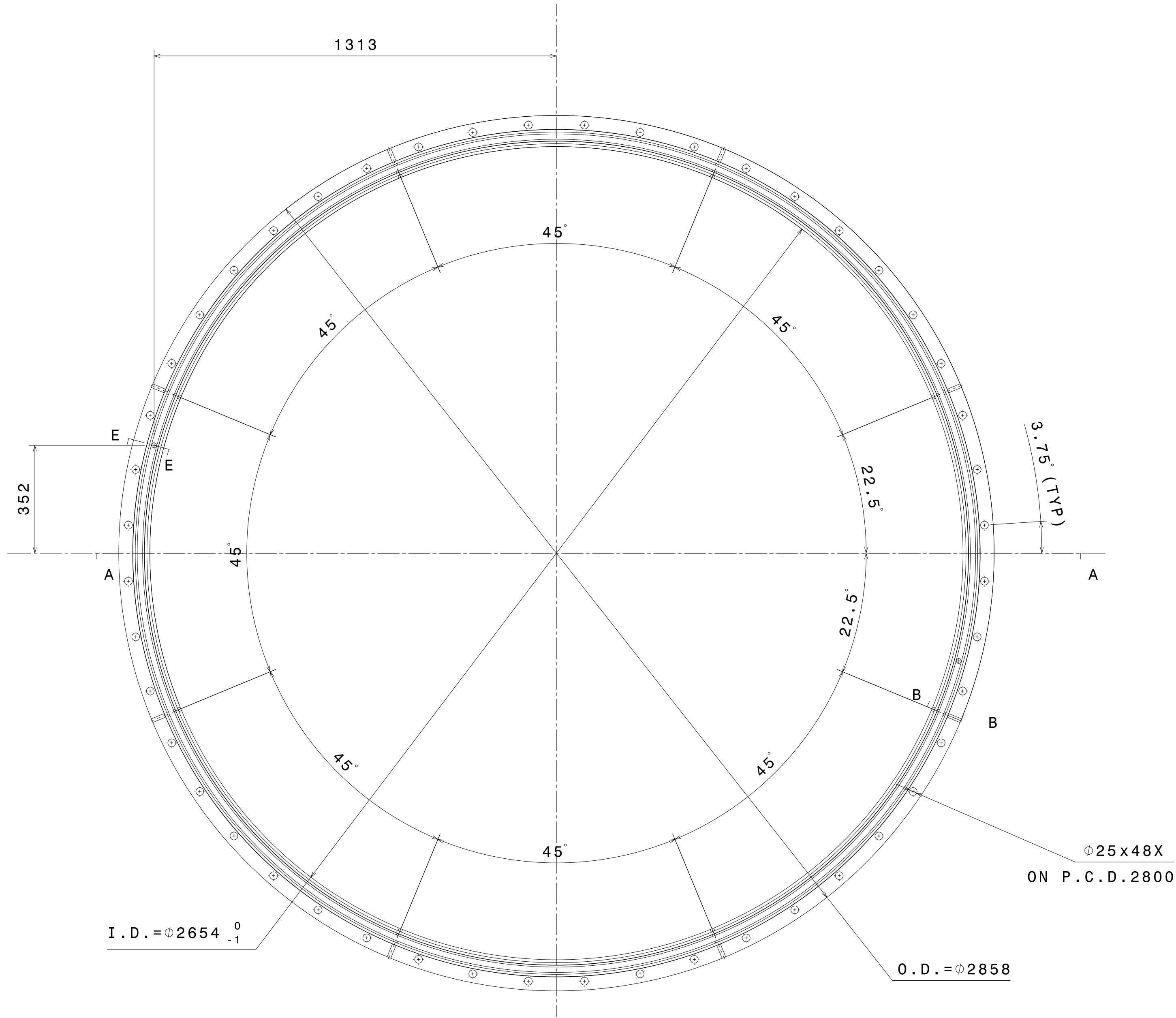


MATERIAL:				▽ 8-25	▽▽ 1.6-8	▽▽▽ 0.025-1.6	▽▽▽▽ < 0.025	REVISION COLUMN						MED	SIZE A1	 INSTITUTE FOR PLASMA RESEARCH (LIGO-INDIA) BHAT, GANDHINAGAR-382 428.				
CO-ORDINATED BY								REV	ZONE	DESCRIPTION	DATE	REMARKS	APPROVED BY	ALL DIMENSIONS ARE IN "mm" UNLESS OTHERWISE STATED						
MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS																	SCALE AS NOTED DATE		 TITLE	
LENGTH IN mm OF SHORTER SIDE OF ANGLES				LENGTH OR DIA	UPTO 6	6-30	30-120	120-315							DRAWN A.N.N. 05/07/2015		LOWER PART			
UPTO 10	10-50	50-120	OVER 120-400												CHECKED R.K.		REF DRG NO: VB01-001-R1 REV R1			
+1'	+0'-30'	+0'-20'	+0'-10'		±0.1	±0.2	±0.3	±0.5							APPROVED M.K.G.		DRG.NO VB01-003-R1 SHEET 05 OF 09			

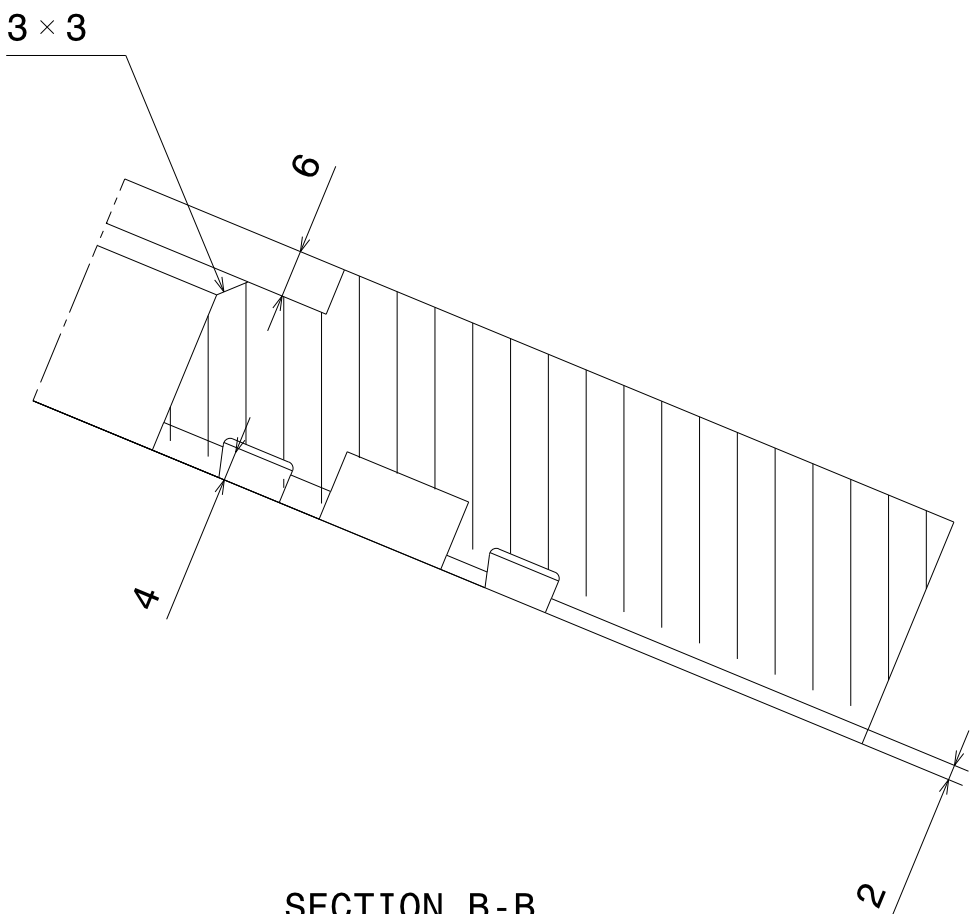


④ FLANGE GROOVED (60.5" ID)

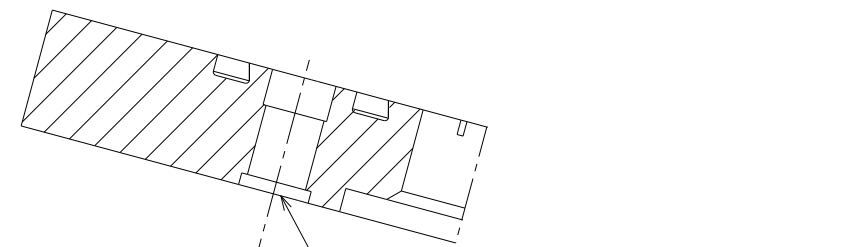
MATERIAL:	▽ 8-25	▽▽ 1.6-8	▽▽▽ 0.025-1.6	▽▽▽▽ < 0.025	REVISION COLUMN							MED	SIZE A1	 INSTITUTE FOR PLASMA RESEARCH (LIGO-INDIA) BHAT, GANDHINAGAR-382 428.		
CO-ORDINATED BY					REV	ZONE	DESCRIPTION	DATE	REMARKS	APPROVED BY	ALL DIMENSIONS ARE IN "mm" UNLESS OTHERWISE STATED					
MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS												SCALE	AS NOTED	DATE	 TITLE	
LENGTH IN mm OF SHORTER SIDE OF ANGLES												DRAWN	A. N. N.	05/07/2015	LOWER PART	
UPTO 10	10-50	50-120	OVER 120-400	LENGTH OR DIA	UPTO 6	6-30	30-120	120-315				CHECKED	R. K.		REF DRG NO: VB01-001-R1	REV R1
±1'	+0°-30'	+0°-20'	+0°-10'		±0.1	±0.2	±0.3	±0.5				APPROVED	M. K. G.		DRG. NO VB01-003-R1	SHEET 06 OF 09



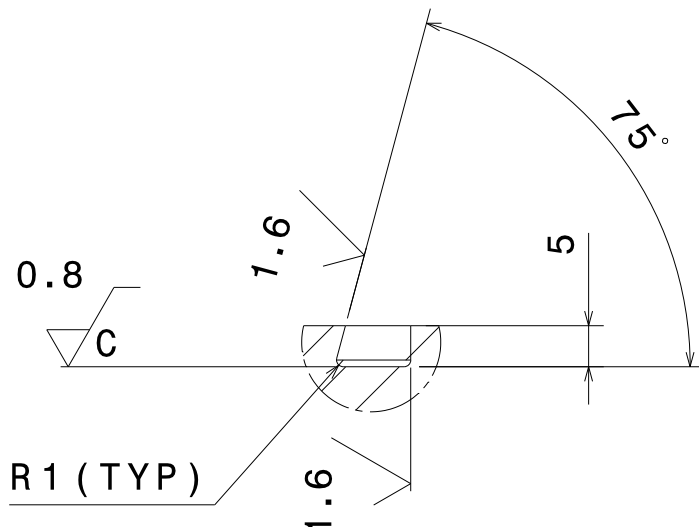
FRONT VIEW
SCALE-1:10



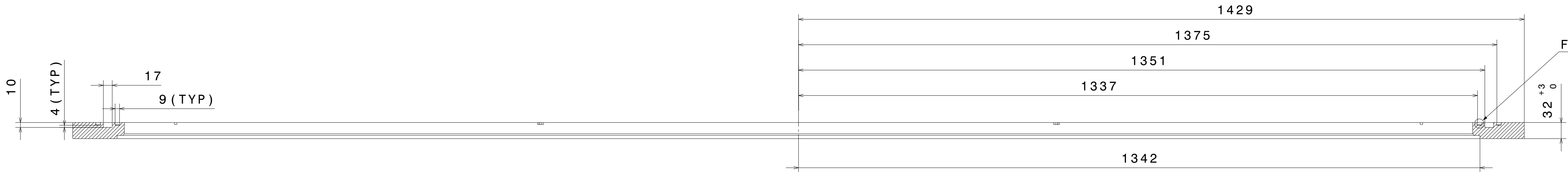
SECTION B-B
SCALE-1:1



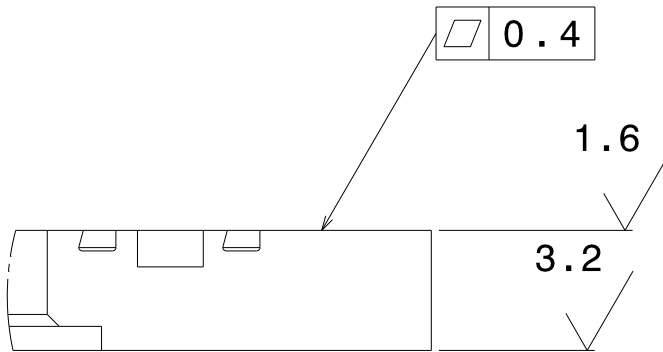
SECTION E-E
SCALE-1:2



DETAIL VIEW-F
SCALE-1:1

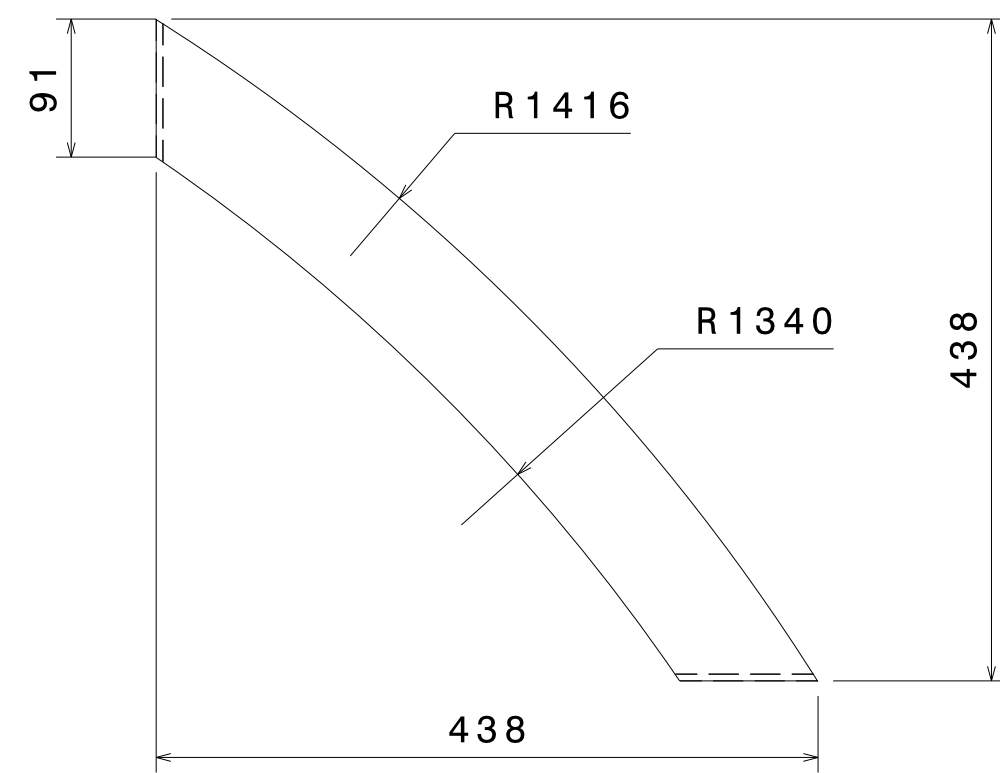


SECTION A-A
SCALE-1:5

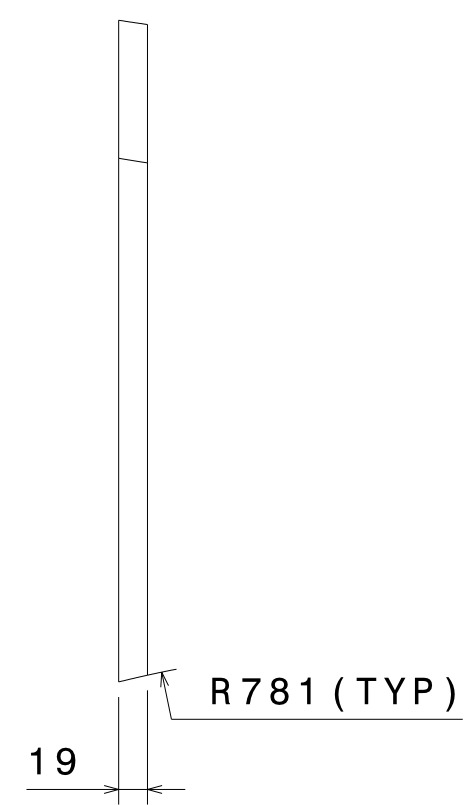


5 FLANGE GROOVED (104.5" ID)

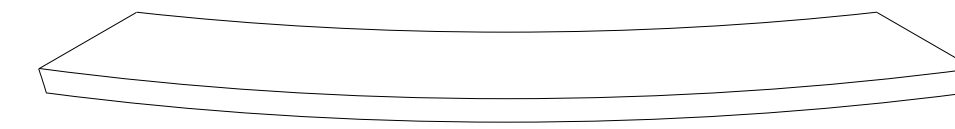
MATERIAL:		▽ 8-25		▽▽ 1.6-8		▽▽▽ 0.025-1.6		▽▽▽▽ < 0.025		REVISION COLUMN						MED		SIZE A1			INSTITUTE FOR PLASMA RESEARCH (LIGO-INDIA)									
CO-ORDINATED BY										REV	ZONE	DESCRIPTION		DATE	REMARKS	APPROVED BY		ALL DIMENSIONS ARE IN "mm" UNLESS OTHERWISE STATED				BHAT, GANDHINAGAR-382 428.								
MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS																				SCALE	AS NOTED	DATE		TITLE						
LENGTH IN mm OF SHORTER SIDE OF ANGLES				LENGTH OR DIA	UPTO 6	6-30	30-120		120-315												DRAWN	A.N.N.	05/07/2015	THIRD ANGLE PROJECTION	LOWER PART					
UPTO 10	10-50	50-120		OVER 120-400																				CHECKED	R.K.	REF DRG NO: VB01-001-R1		REV R1		
±1'	±0'-30'	±0'-20'		±0'-10'		+0.1	+0.2	+0.3		+0.5																APPROVED	M.K.G.	DRG.NO VB01-003-R1		SHEET 07 OF 09



FRONT VIEW

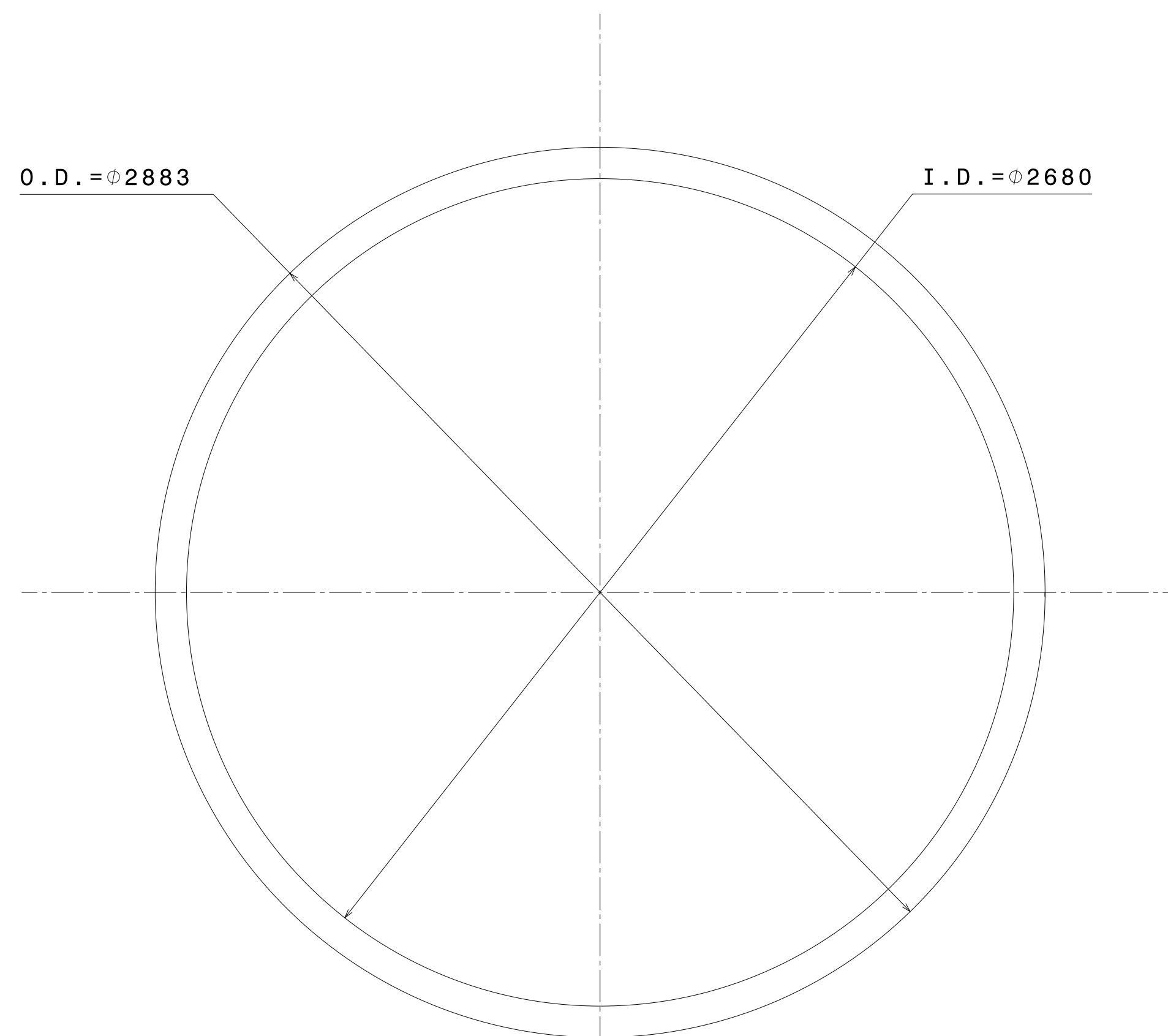


SIDE VIEW

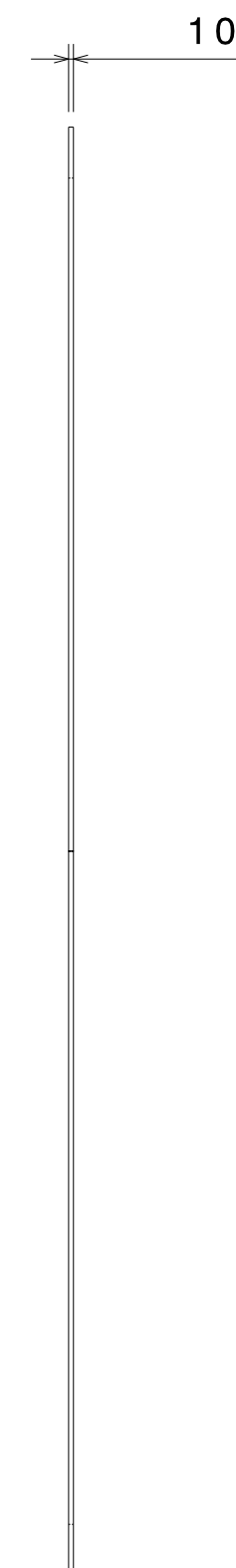


ISOMETRIC VIEW

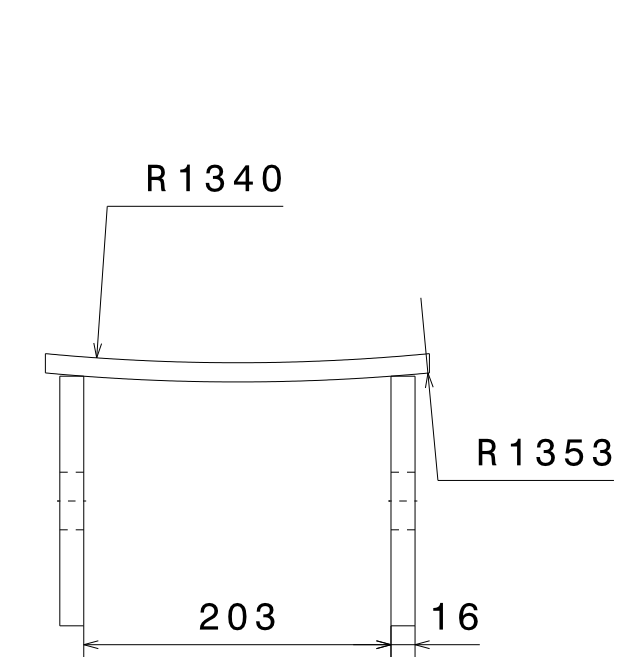
⑧ STIFFENER 60" PORT
SCALE-1:5



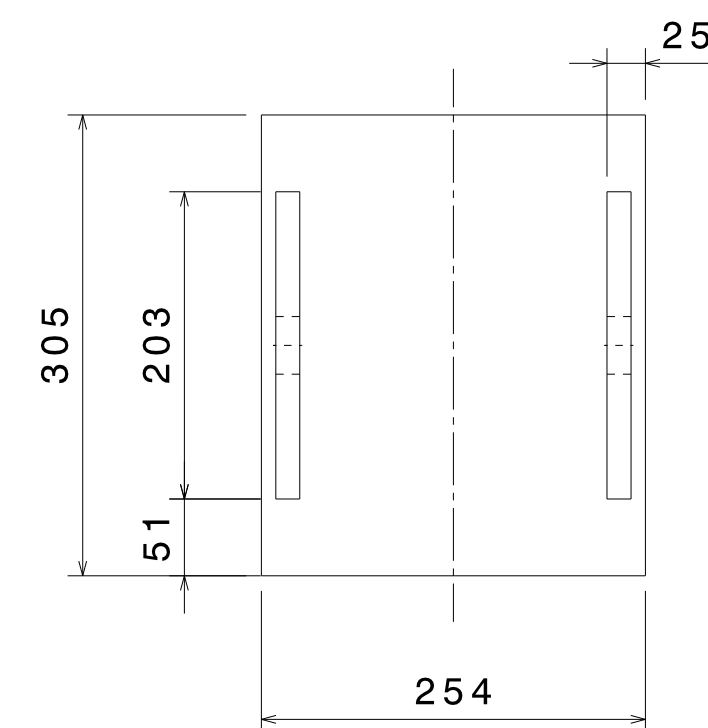
FRONT VIEW



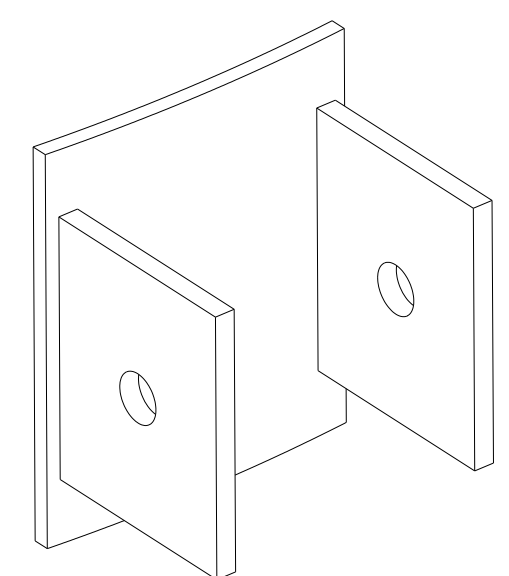
SIDE VIEW



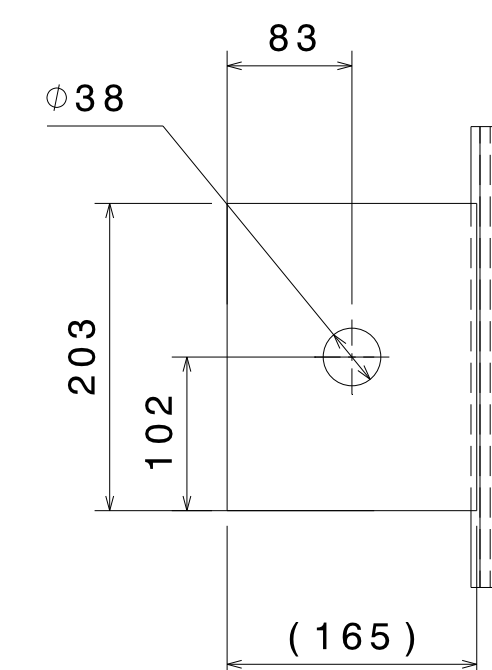
TOP VIEW



FRONT VIEW

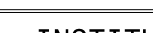


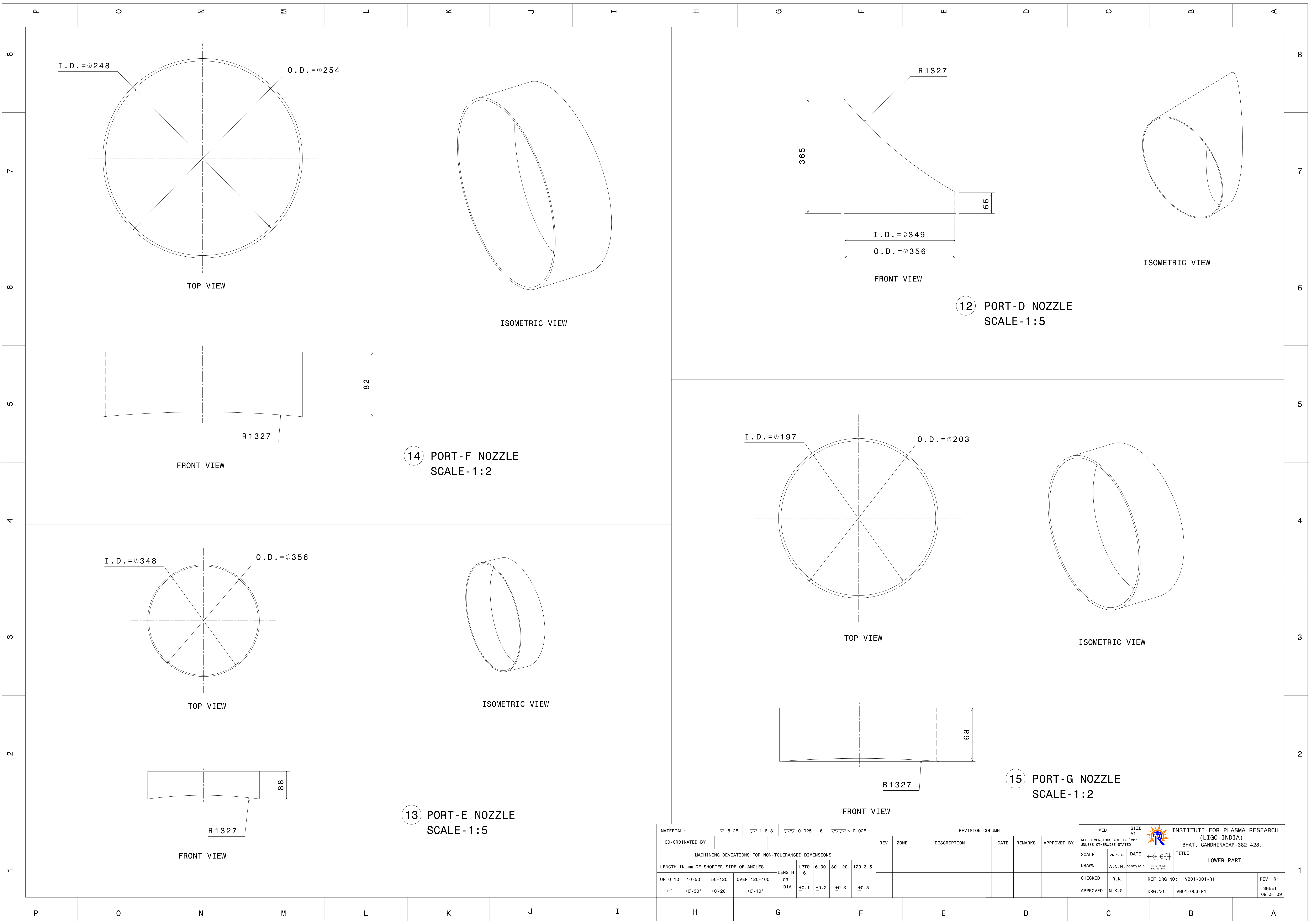
ISOMETRIC VIEW



SIDE VIEW

10 SUPPORT PAD
SCALE - 1:5

MATERIAL :		▽ 8-25		▽▽ 1.6-8		▽▽▽ 0.025-1.6		▽▽▽▽ < 0.025		REVISION COLUMN							MED		SIZE A1		 INSTITUTE FOR PLASMA RESEARCH (LIGO -INDIA)										
CO-ORDINATED BY										REV	ZONE	DESCRIPTION				DATE	REMARKS	APPROVED BY		ALL DIMENSIONS ARE IN "mm" UNLESS OTHERWISE STATED				BHAT, GANDHINAGAR-382 428.							
MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS																				SCALE		AS NOTED		DATE		 TITLE		LOWER PART			
LENGTH IN mm OF SHORTER SIDE OF ANGLES								LENGTH OR DIA		UPTO 6		6-30		30-120		120-315		DRAWN		A.N.N.		06/07/2016									
UPTO 10		10-50		50-120		OVER 120-400												CHECKED		R.K.						REF DRG NO:		VB01-001-R1		REV R1	
±1°		+0°-30'		+0°-20'		+0°-10'				_0_-1		_0_-2		_0_-3		_0_-5		APPROVED		M.K.G.						DRG.NO		VB01-003-R1		SHEET 08 OF 09	



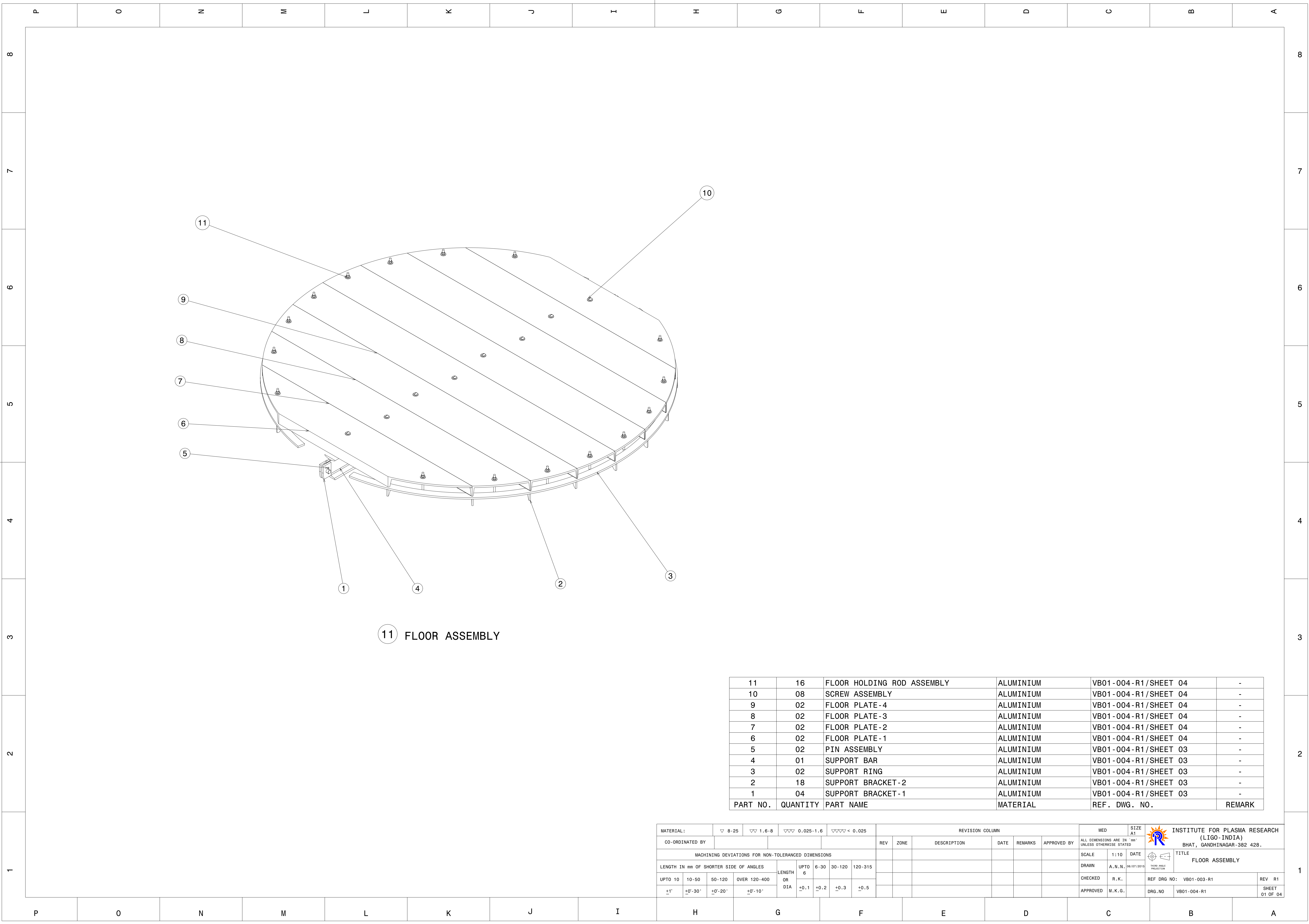
14 PORT-F NOZZLE
SCALE-1:2

12 PORT-D NOZZLE
SCALE-1:5

13 PORT-E NOZZLE
SCALE-1:5

15 PORT-G NOZZLE
SCALE-1:2

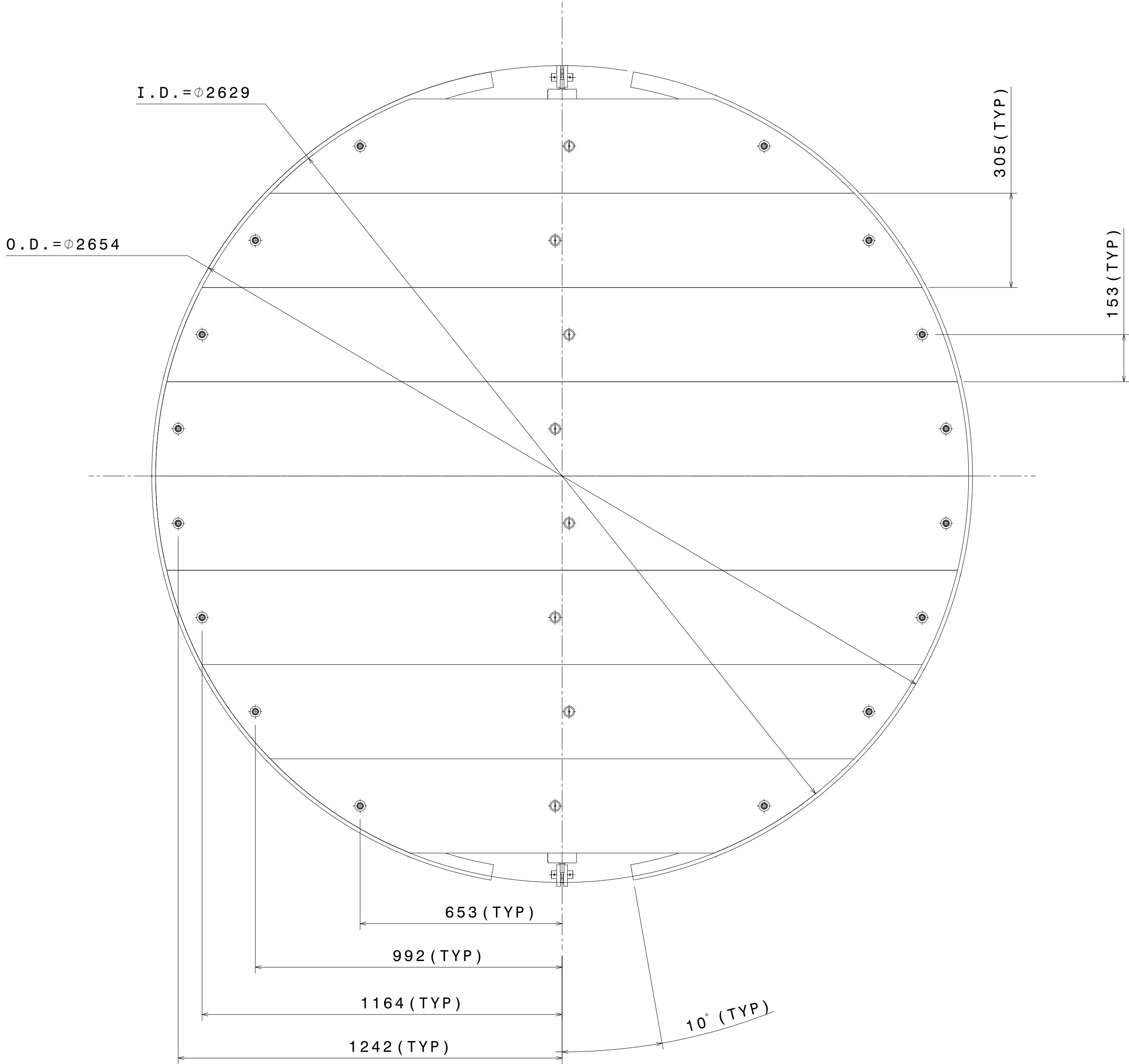
MATERIAL:		▽ 8-25	▽▽ 1.6-8	▽▽▽ 0.025-1.6	▽▽▽▽ < 0.025	REVISION COLUMN						MED	SIZE A1		INSTITUTE FOR PLASMA RESEARCH (LIGO-INDIA) BHAT, GANDHINAGAR-382 428.		
CO-ORDINATED BY						REV	ZONE	DESCRIPTION	DATE	REMARKS	APPROVED BY	ALL DIMENSIONS ARE IN "mm" UNLESS OTHERWISE STATED					
MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS												SCALE	AS NOTED	DATE		TITLE LOWER PART	
LENGTH IN mm OF SHORTER SIDE OF ANGLES					LENGTH OR DIA	UPTO 6	6-30	30-120	120-315			DRAWN	A.N.N.	05/07/2015			
UPTO 10	10-50	50-120	OVER 120-400										CHECKED	R.K.	REF DRG NO: VB01-001-R1	REV R1	
±1'	+0°-30'	+0°-20'	+0°-10'			+0.1	+0.2	+0.3	+0.5				APPROVED	M.K.G.	DRG.NO VB01-003-R1	SHEET 09 OF 09	



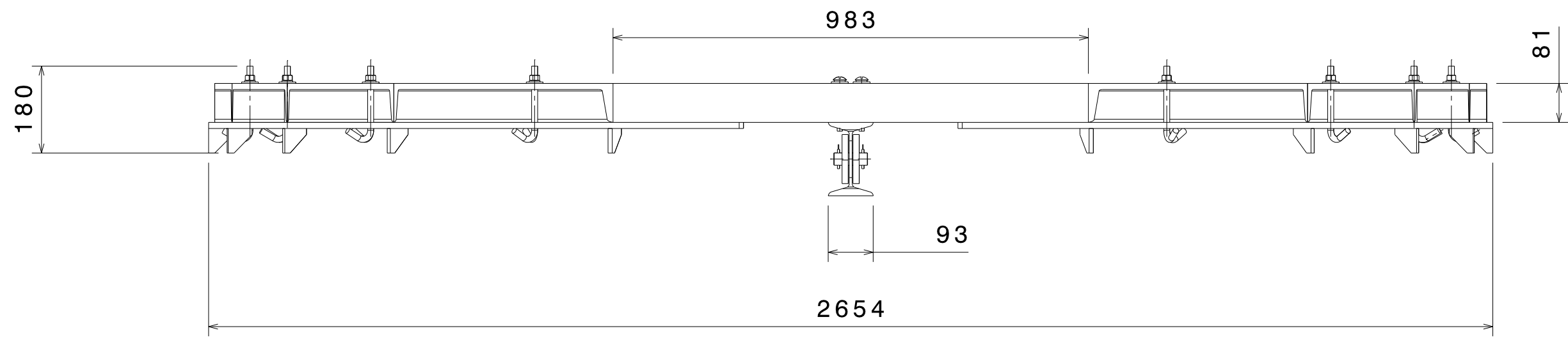
11 FLOOR ASSEMBLY

11	16	FLOOR HOLDING ROD ASSEMBLY	ALUMINIUM	VB01-004-R1/SHEET 04	-
10	08	SCREW ASSEMBLY	ALUMINIUM	VB01-004-R1/SHEET 04	-
9	02	FLOOR PLATE-4	ALUMINIUM	VB01-004-R1/SHEET 04	-
8	02	FLOOR PLATE-3	ALUMINIUM	VB01-004-R1/SHEET 04	-
7	02	FLOOR PLATE-2	ALUMINIUM	VB01-004-R1/SHEET 04	-
6	02	FLOOR PLATE-1	ALUMINIUM	VB01-004-R1/SHEET 04	-
5	02	PIN ASSEMBLY	ALUMINIUM	VB01-004-R1/SHEET 03	-
4	01	SUPPORT BAR	ALUMINIUM	VB01-004-R1/SHEET 03	-
3	02	SUPPORT RING	ALUMINIUM	VB01-004-R1/SHEET 03	-
2	18	SUPPORT BRACKET-2	ALUMINIUM	VB01-004-R1/SHEET 03	-
1	04	SUPPORT BRACKET-1	ALUMINIUM	VB01-004-R1/SHEET 03	-
PART NO.	QUANTITY	PART NAME	MATERIAL	REF. DWG. NO.	REMARK

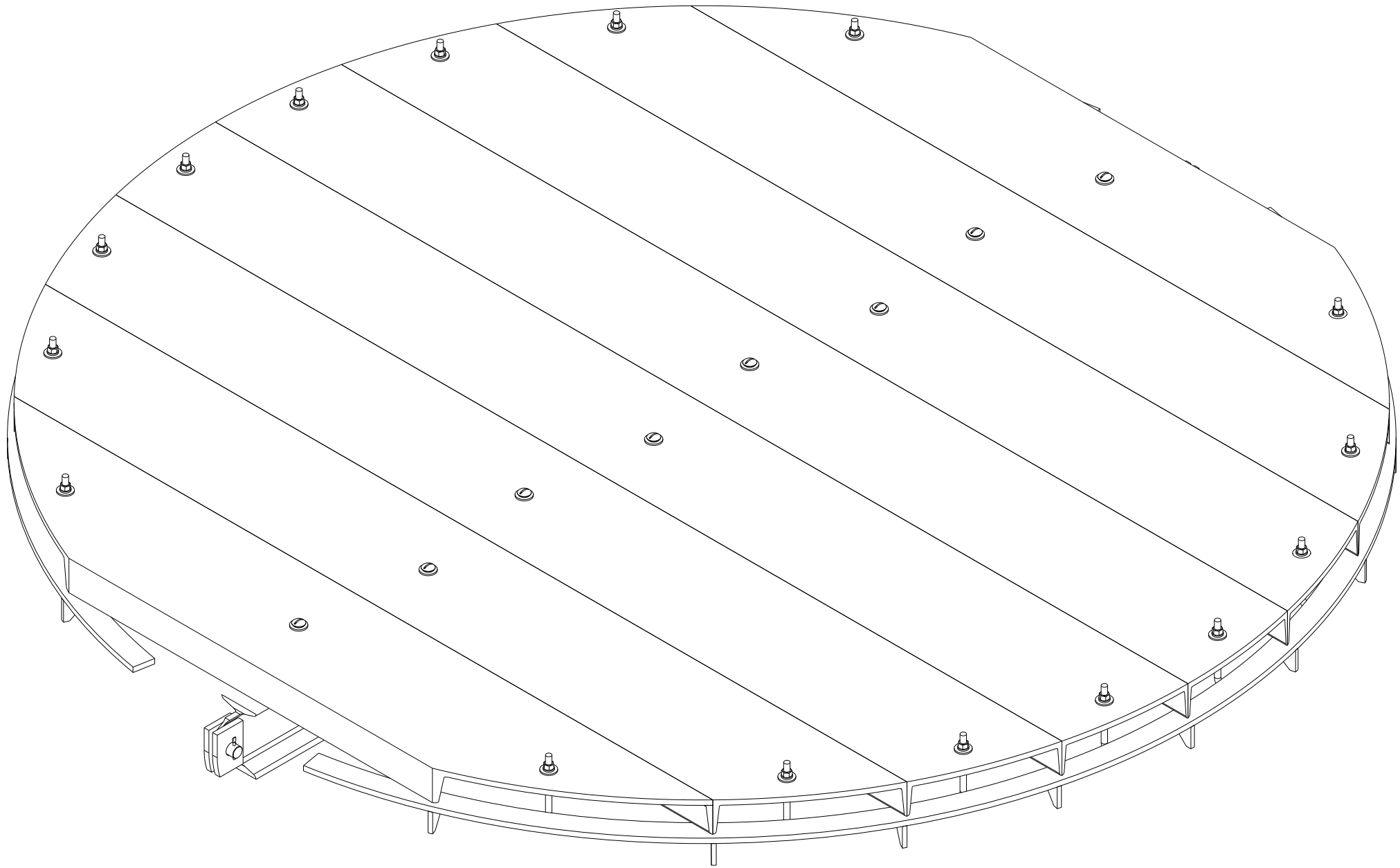
MATERIAL:				▽ 8-25	▽▽ 1.6-8	▽▽▽ 0.025-1.6	▽▽▽▽ < 0.025	REVISION COLUMN					MED		SIZE A1	 INSTITUTE FOR PLASMA RESEARCH (LIGO-INDIA)				
CO-ORDINATED BY								REV	ZONE	DESCRIPTION	DATE	REMARKS	APPROVED BY	ALL DIMENSIONS ARE IN "mm" UNLESS OTHERWISE STATED.				BHAT, GANDHINAGAR-382 428.		
MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS												SCALE		1:10	DATE	 TITLE				
LENGTH IN mm OF SHORTER SIDE OF ANGLES								LENGTH OR DIA	UPTO 6	6-30	30-120	120-315	DRAWN		A.N.N.	06/07/2016	FLOOR ASSEMBLY			
UPTO 10	10-50	50-120	OVER 120-400										CHECKED	R.K.	REF DRG NO:	VB01-003-R1		REV R1		
±1'	±0'-30'	±0'-20'	±0'-10'		±0.1	±0.2	±0.3		±0.5				APPROVED	M.K.G.	DRG. NO	VB01-004-R1		SHEET 01 OF 04		



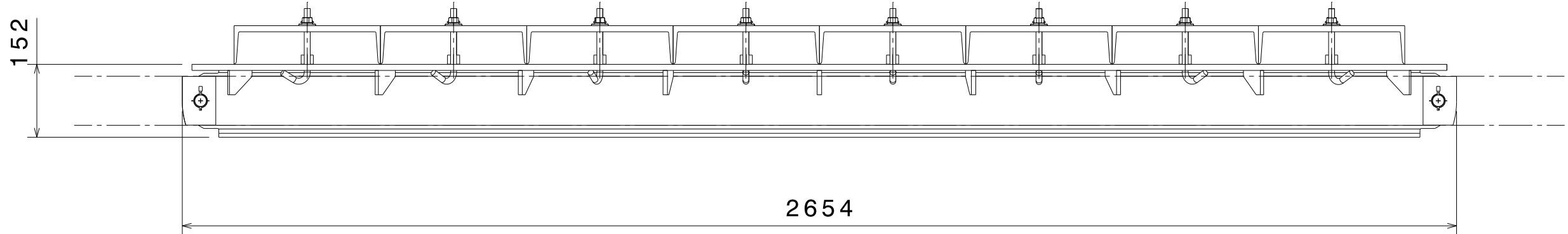
TOP VIEW



FRONT VIEW

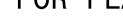


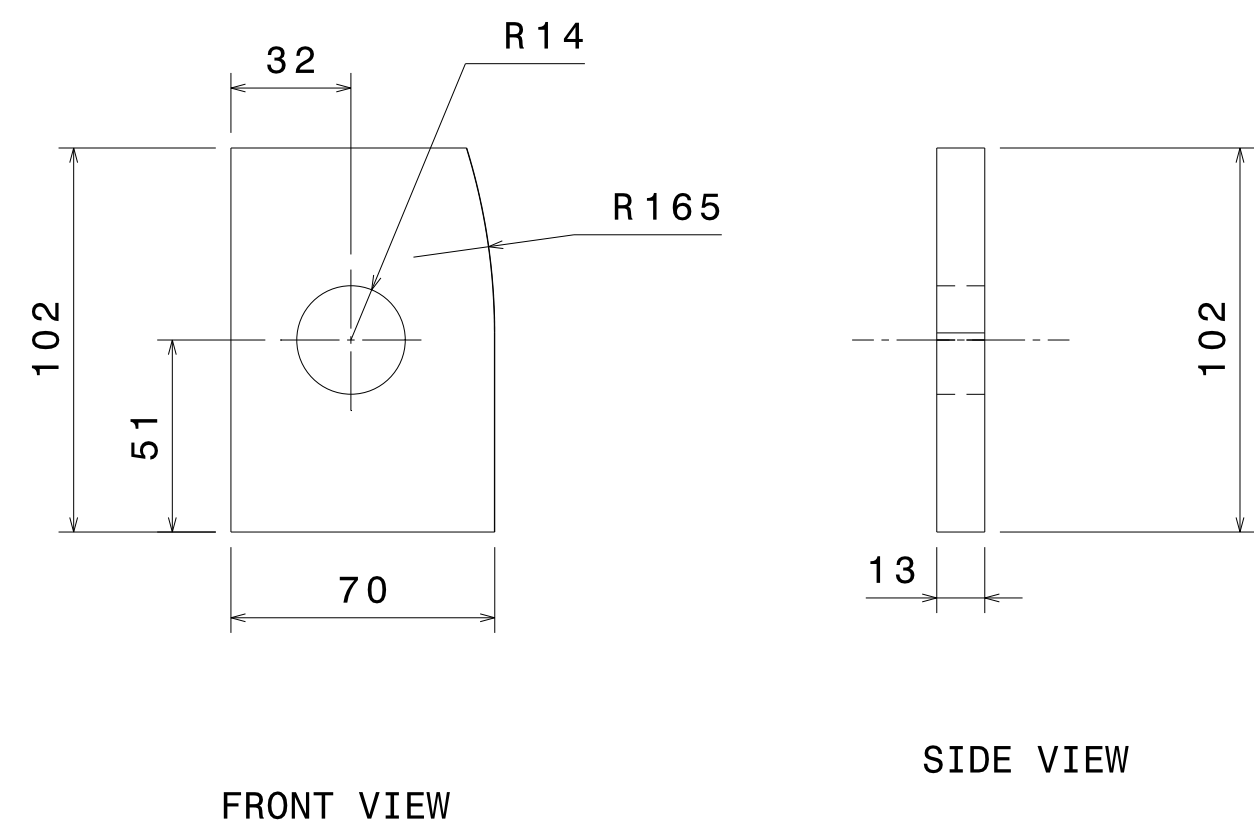
ISOMETRIC VIEW



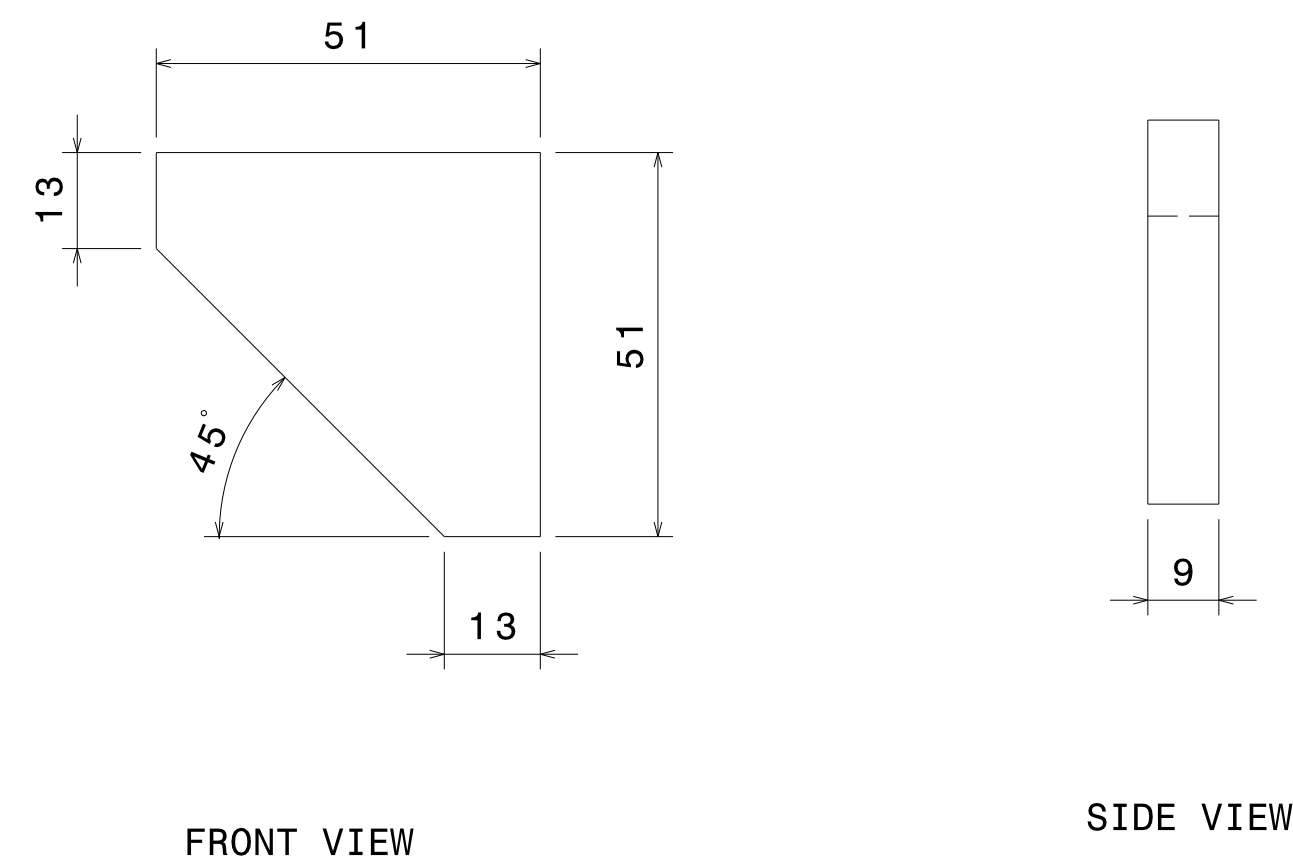
SIDE VIEW

11 FLOOR ASSEMBLY

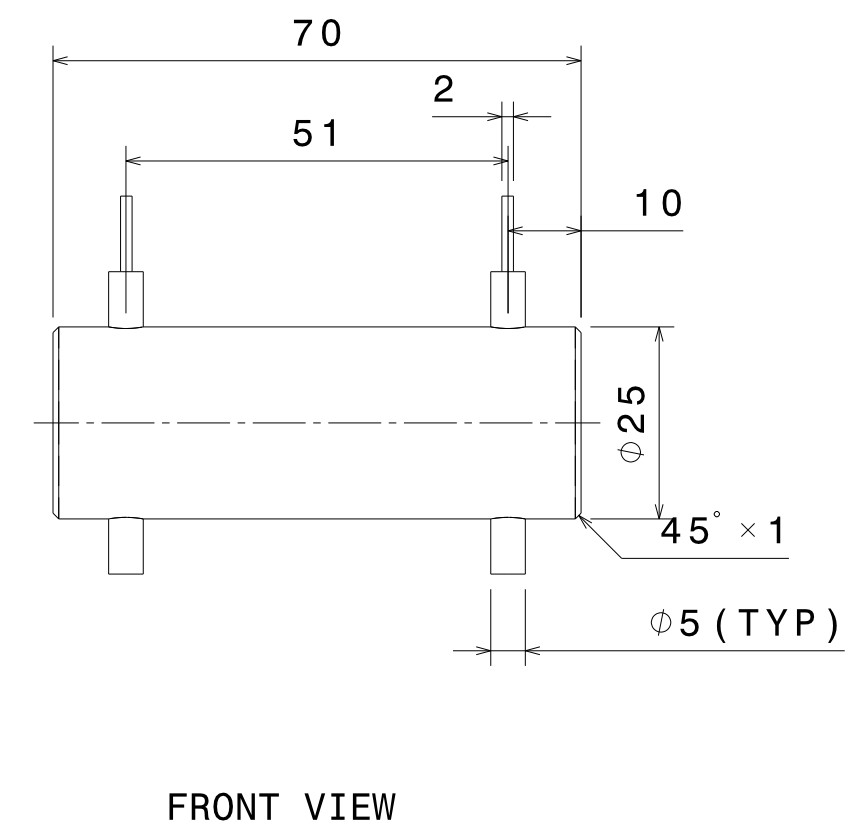
MATERIAL:	▽ 8-25	▽▽ 1.6-8	▽▽▽ 0.025-1.6	▽▽▽▽ < 0.025	REVISION COLUMN						MED	SIZE A1		INSTITUTE FOR PLASMA RESEARCH (LIGO-INDIA)					
CO-ORDINATED BY					REV	ZONE	DESCRIPTION	DATE	REMARKS	APPROVED BY	ALL DIMENSIONS ARE IN "mm" UNLESS OTHERWISE STATED	BHAT, GANDHINAGAR-382 428.							
MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS															SCALE	1:10	DATE		TITLE
LENGTH IN mm OF SHORTER SIDE OF ANGLES					UPTO 6	6-30	30-120	120-315			DRAWN	A.N.N.	06/07/2015	FLOOR ASSEMBLY					
UPTO 10	10-50	50-120	OVER 120-400	LENGTH OR DIA	+0.1	+0.2	+0.3	+0.5			CHECKED	R.K.	REF DRG NO: VB01-003-R1		REV R1				
±1'	+0'-30'	+0'-20'	+0'-10'								APPROVED	M.K.G.	DRG.NO	VB01-004-R1	SHEET 02 OF 04				



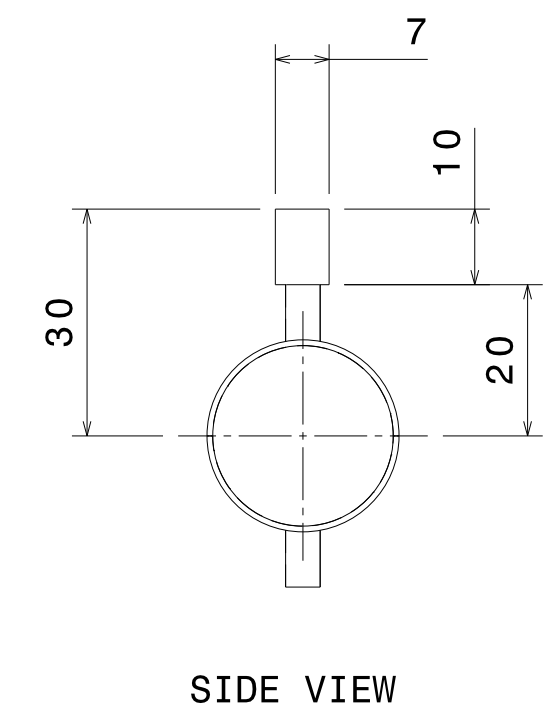
① SUPPORT BRACKET - 1
SCALE - 1:2



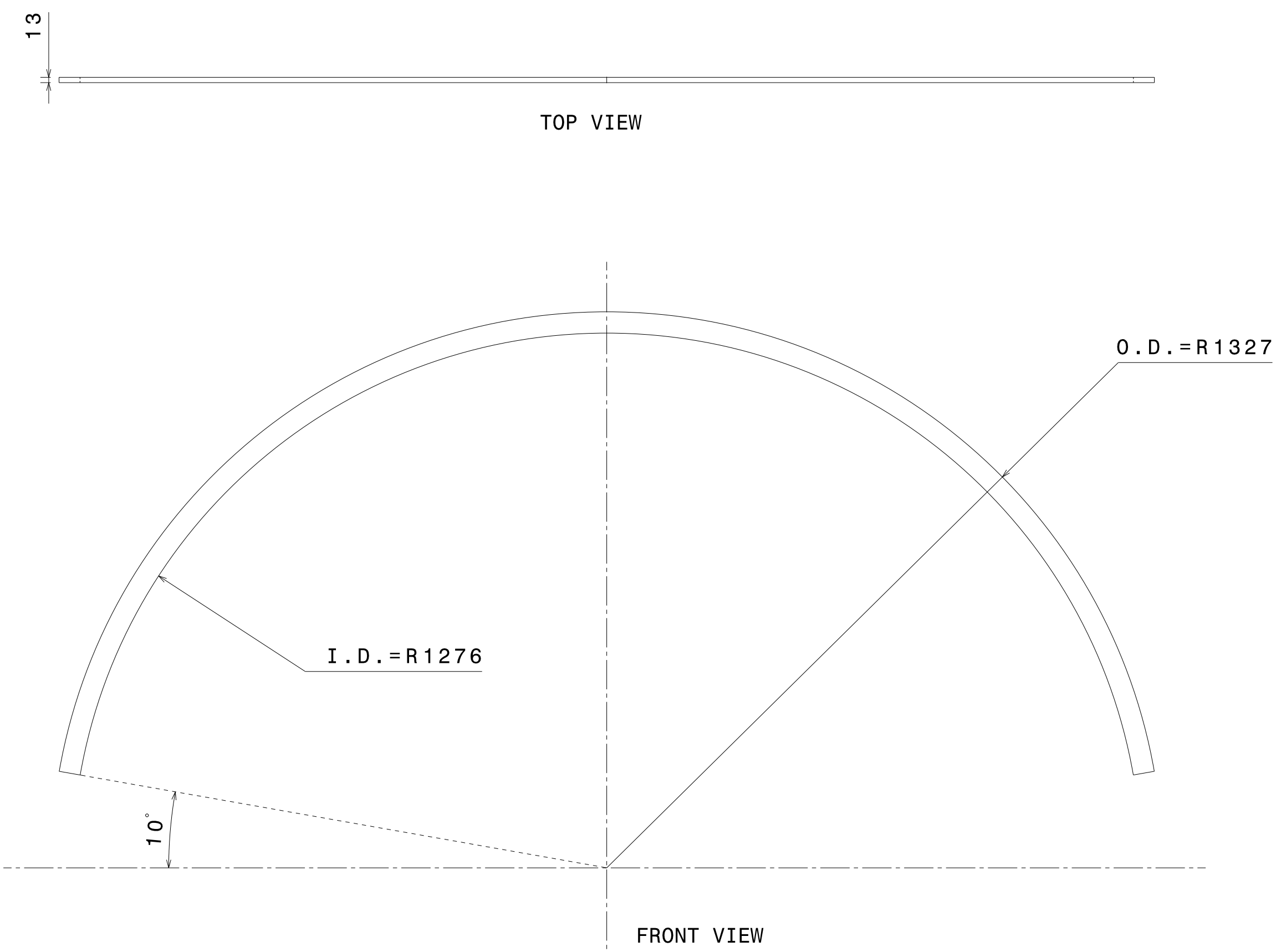
② SUPPORT BRACKET-2
SCALE-1:1



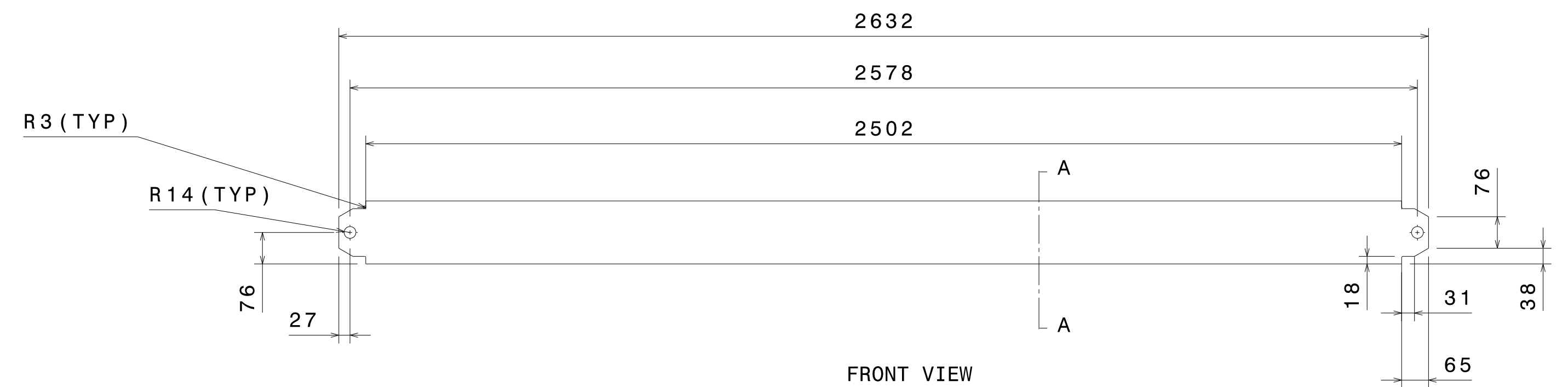
⑤ PIN ASSEMBLY
SCALE - 1:1



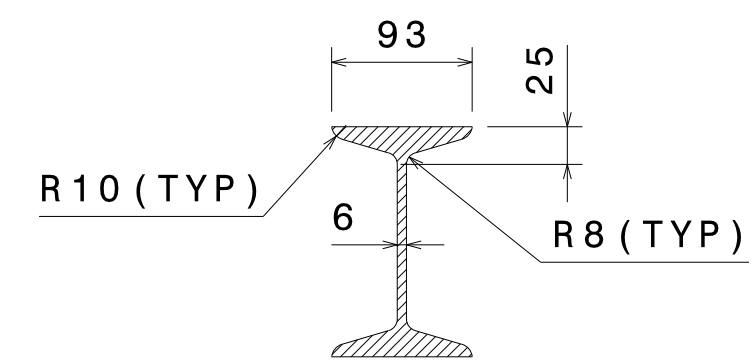
ISOMETRIC VIEW



③ SUPPORT RING
SCALE - 1:10

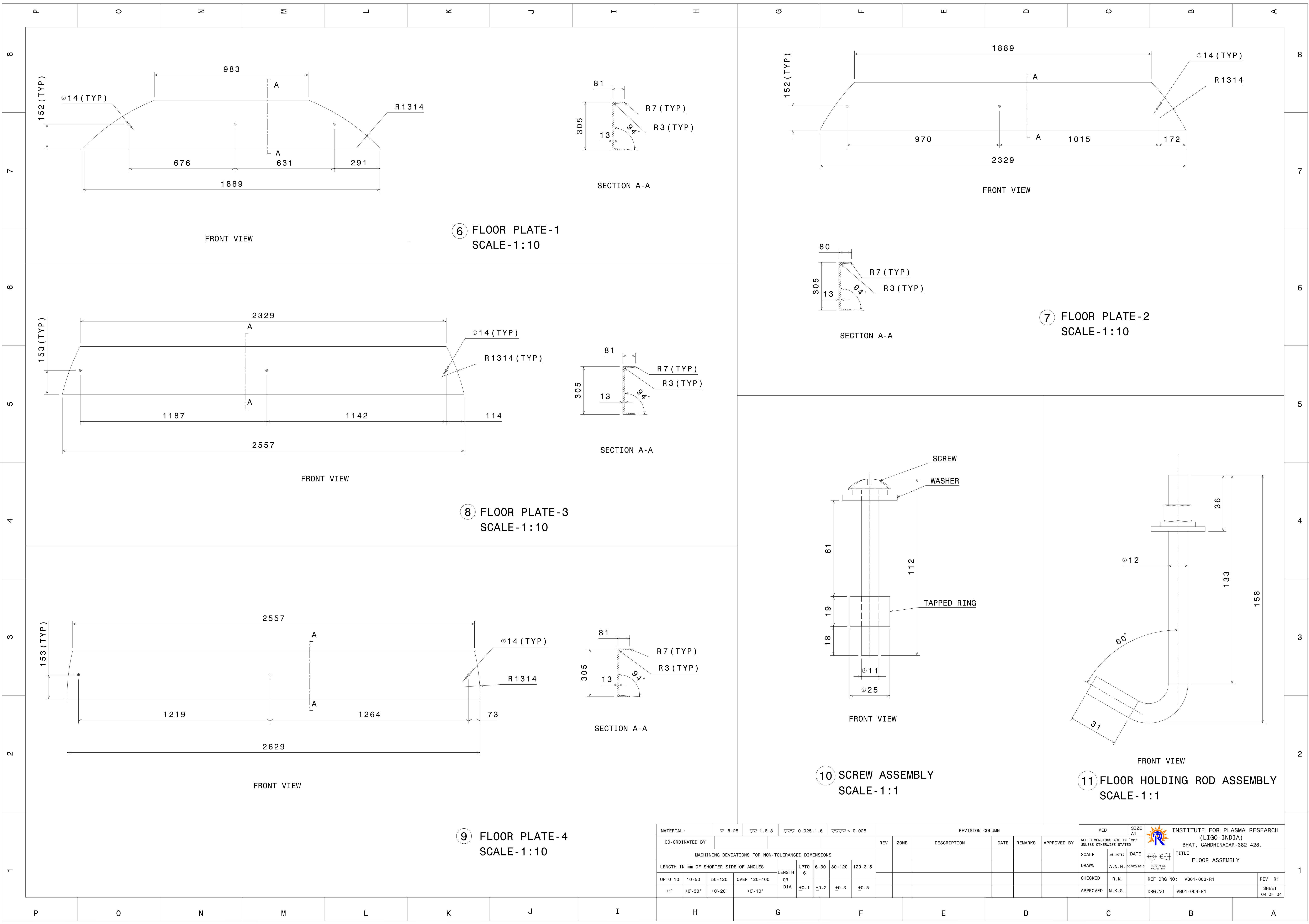


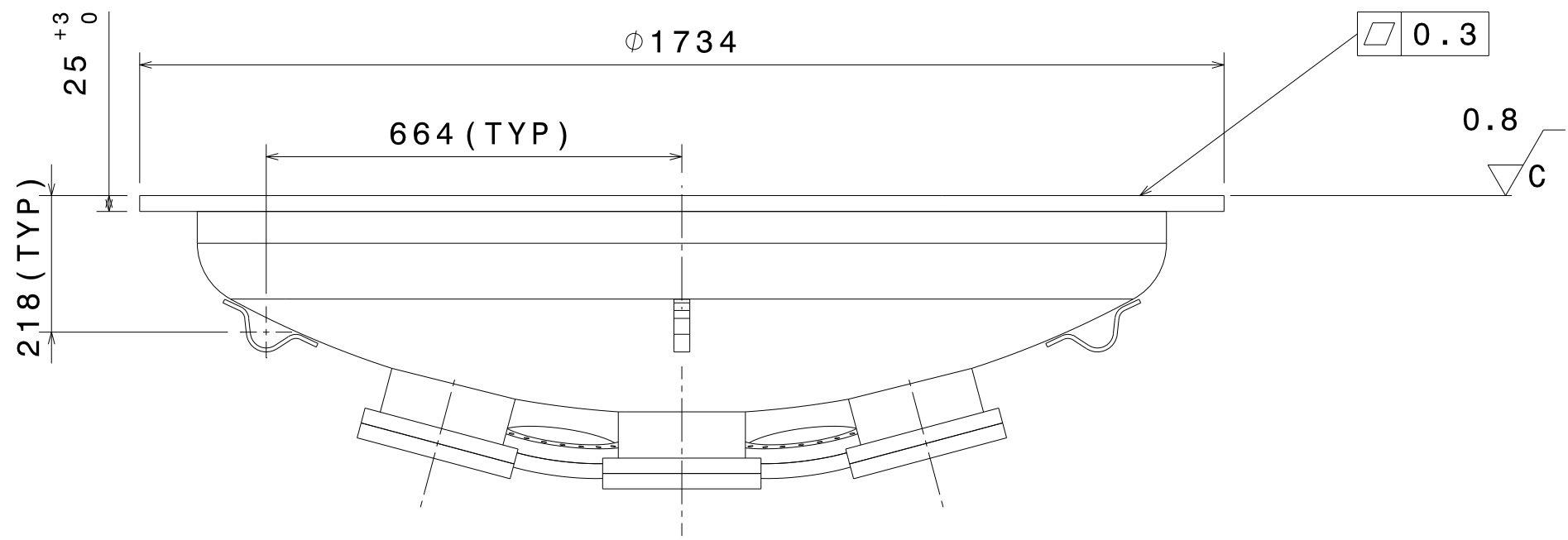
4 SUPPORT BAR
SCALE - 1:10



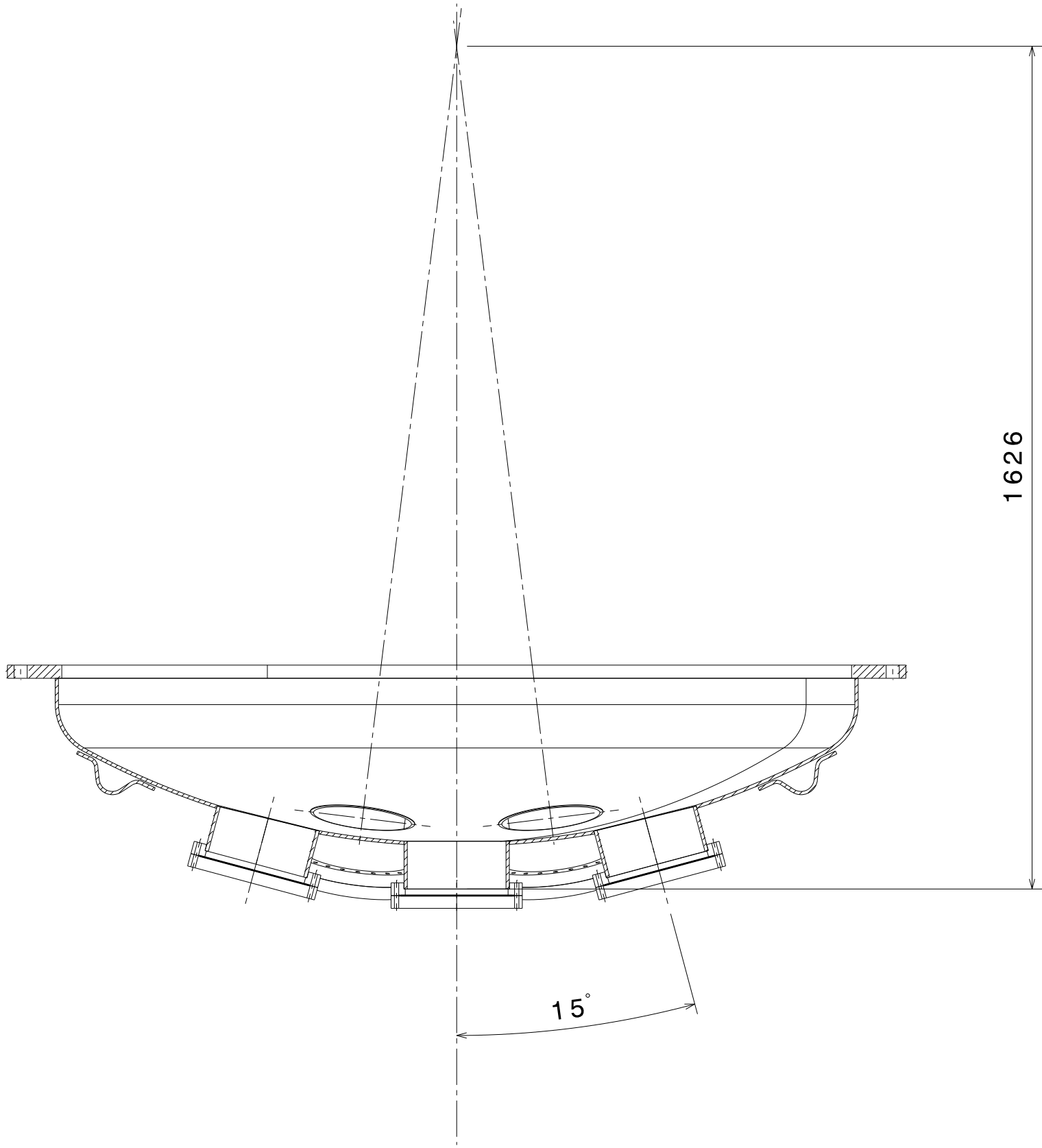
SECTION A-A
SCALE - 1:5

MATERIAL:	▽ 8-25	▽▽ 1.6-8	▽▽▽ 0.025-1.6	▽▽▽▽ < 0.025	REVISION COLUMN						MED	SIZE A1	 INSTITUTE FOR PLASMA RESEARCH (LIGO - INDIA)		
CO-ORDINATED BY					REV	ZONE	DESCRIPTION	DATE	REMARKS	APPROVED BY	ALL DIMENSIONS ARE IN "mm" UNLESS OTHERWISE STATED		BHAT, GANDHINAGAR-382 428.		
MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS											SCALE	AS NOTED	DATE	 TITLE	
LENGTH IN mm OF SHORTER SIDE OF ANGLES											DRAWN	A.N.N.	06/07/2015	FLOOR ASSEMBLY	
UPTO 10	10-50	50-120	OVER 120-400	LENGTH OR DIA	UPTO 6	6-30	30-120	120-315			CHECKED	R.K.		REF DRG NO : VB01-003-R1	REV R1
+1°	+0°-30'	+0°-20'	+0°-10'		+0.1	+0.2	+0.3	+0.5			APPROVED	M.K.G.		DRG.NO VB01-004-R1	SHEET 03 OF 04

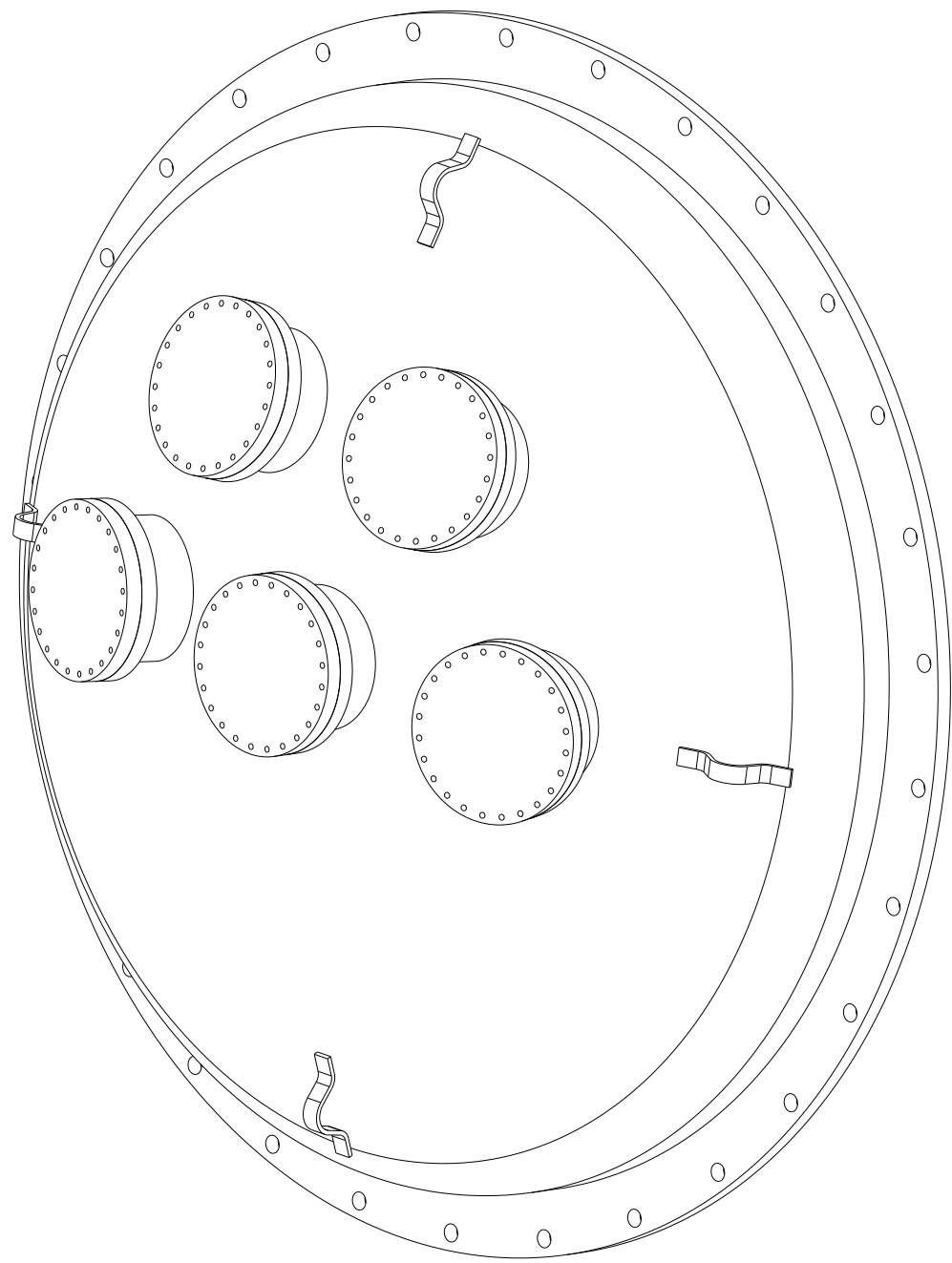




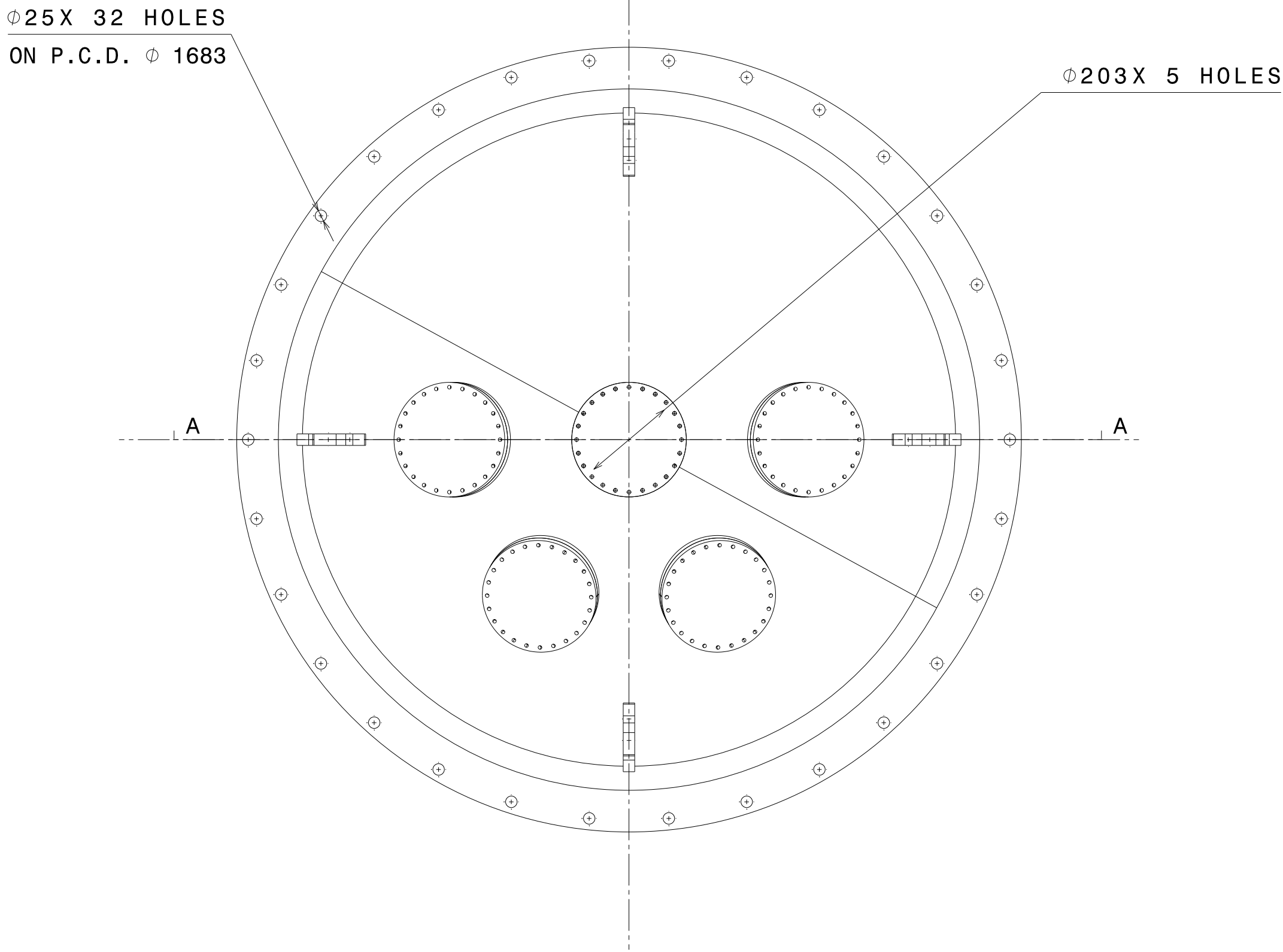
FRONT VIEW



SECTION A-A



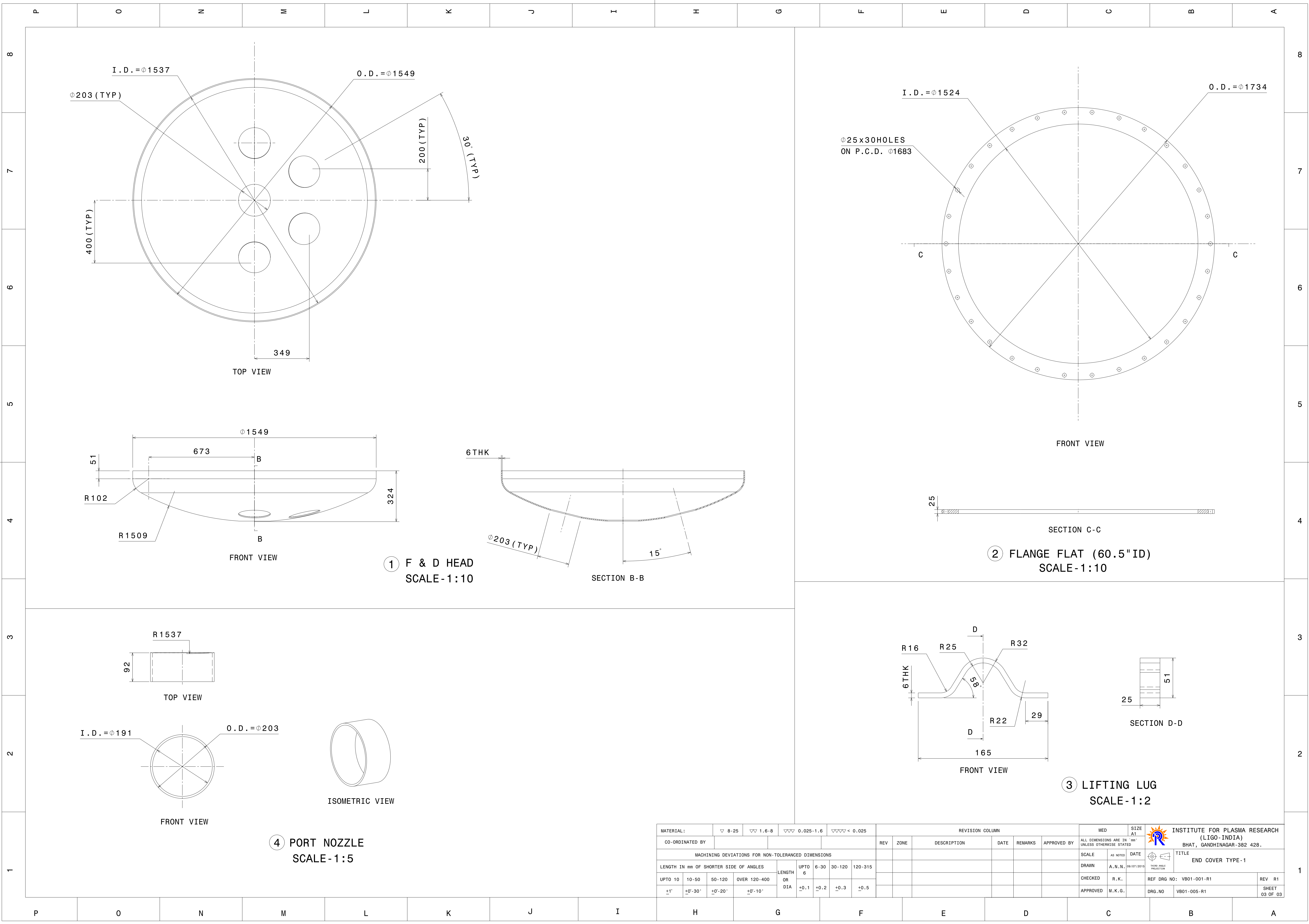
ISOMETRIC VIEW



BOTTOM VIEW

3 END COVER TYPE-1

MATERIAL:				▽ 8-25	▽▽ 1.6-8	▽▽▽ 0.025-1.6	▽▽▽▽ < 0.025	REVISION COLUMN					MED	SIZE A1	 INSTITUTE FOR PLASMA RESEARCH (LIGO-INDIA) BHAT, GANDHINAGAR-382 428.						
CO-ORDINATED BY								REV	ZONE	DESCRIPTION	DATE	REMARKS	APPROVED BY	ALL DIMENSIONS ARE IN "mm" UNLESS OTHERWISE STATED							
MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS												SCALE	1:10	DATE		TITLE					
LENGTH IN mm OF SHORTER SIDE OF ANGLES				LENGTH OR DIA	UPTO 6	6-30	30-120	120-315					DRAWN	A.N.N.	09/07/2015	END COVER TYPE-1					
UPTO 10	10-50	50-120	OVER 120-400										CHECKED	R.K.		REF DRG NO: VB01-001-R1		REV R1			
±1'	±0'-30'	±0'-20'	±0'-10'		±0.1	±0.2	±0.3	±0.5					APPROVED	M.K.G.		DRG.NO	VB01-005-R1		SHEET 02 OF 03		



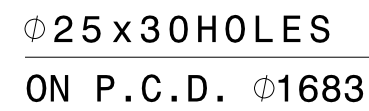
1 F & D HEAD
SCALE-1:10

2 FLANGE FLAT (60.5" ID)
SCALE-1:10

3 LIFTING LUG
SCALE-1:2

4 PORT NOZZLE
SCALE-1:5

MATERIAL:				▽ 8-25	▽▽ 1.6-8	▽▽▽ 0.025-1.6	▽▽▽▽ < 0.025	REVISION COLUMN						MED		SIZE A1		INSTITUTE FOR PLASMA RESEARCH (LIGO-INDIA)									
CO-ORDINATED BY								REV	ZONE	DESCRIPTION	DATE	REMARKS	APPROVED BY	ALL DIMENSIONS ARE IN "mm" UNLESS OTHERWISE STATED		BHAT, GANDHINAGAR-382 428.											
MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS																		SCALE		AS NOTED	DATE		TITLE				
LENGTH IN mm OF SHORTER SIDE OF ANGLES					LENGTH OR DIA	UPTO 6	6-30											30-120	120-315	DRAWN			A.N.N.		09/07/2015		END COVER TYPE-1
UPTO 10	10-50	50-120	OVER 120-400	+0.1		+0.2	+0.3											+0.5	CHECKED		R.K.		REF DRG NO: VB01-001-R1		REV R1		
+1'	+0'-30'	+0'-20'	+0'-10'	APPROVED		M.K.G.												DRG.NO		VB01-005-R1		SHEET 03 OF 03					



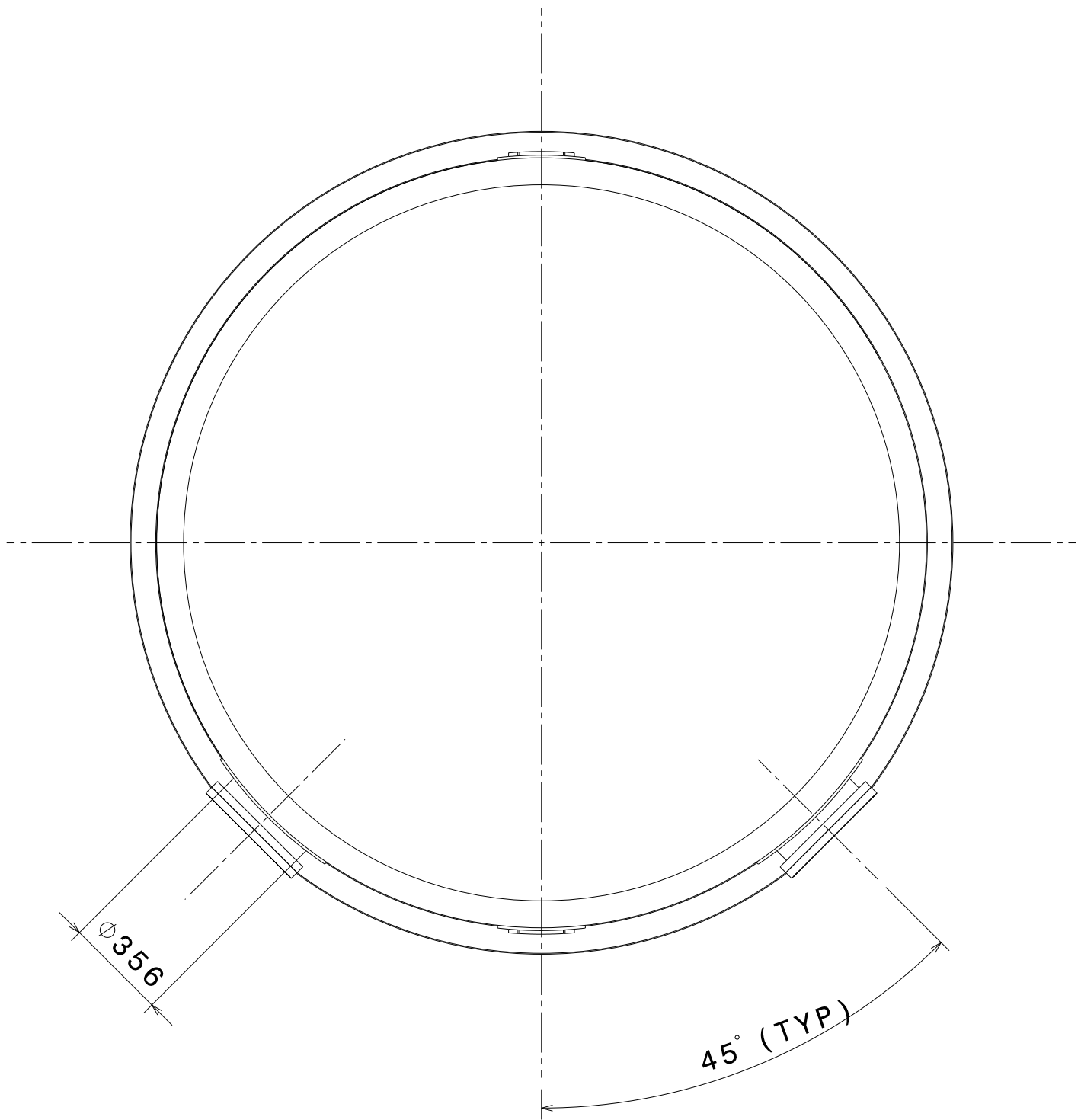
Technical drawing of a 1500mm diameter pipe with a 6mm thickness. The drawing shows a cross-section of the pipe with a central support. Key dimensions include: overall diameter of 1549mm, wall thickness of 6mm (6 THK), and a central support with a diameter of 203mm. The drawing also shows a curved profile of the pipe with a radius of R1509 and a vertical height of 320mm. Other dimensions include 219 (TYP) for the top flange, 25 for the flange thickness, 661 (TYP) for the distance from the center to the start of the curve, 673 for the distance from the center to the end of the curve, 51 for the distance from the center to the top of the curve, and R102 for the radius of the curve at the top.

④ END COVER TYPE-A11

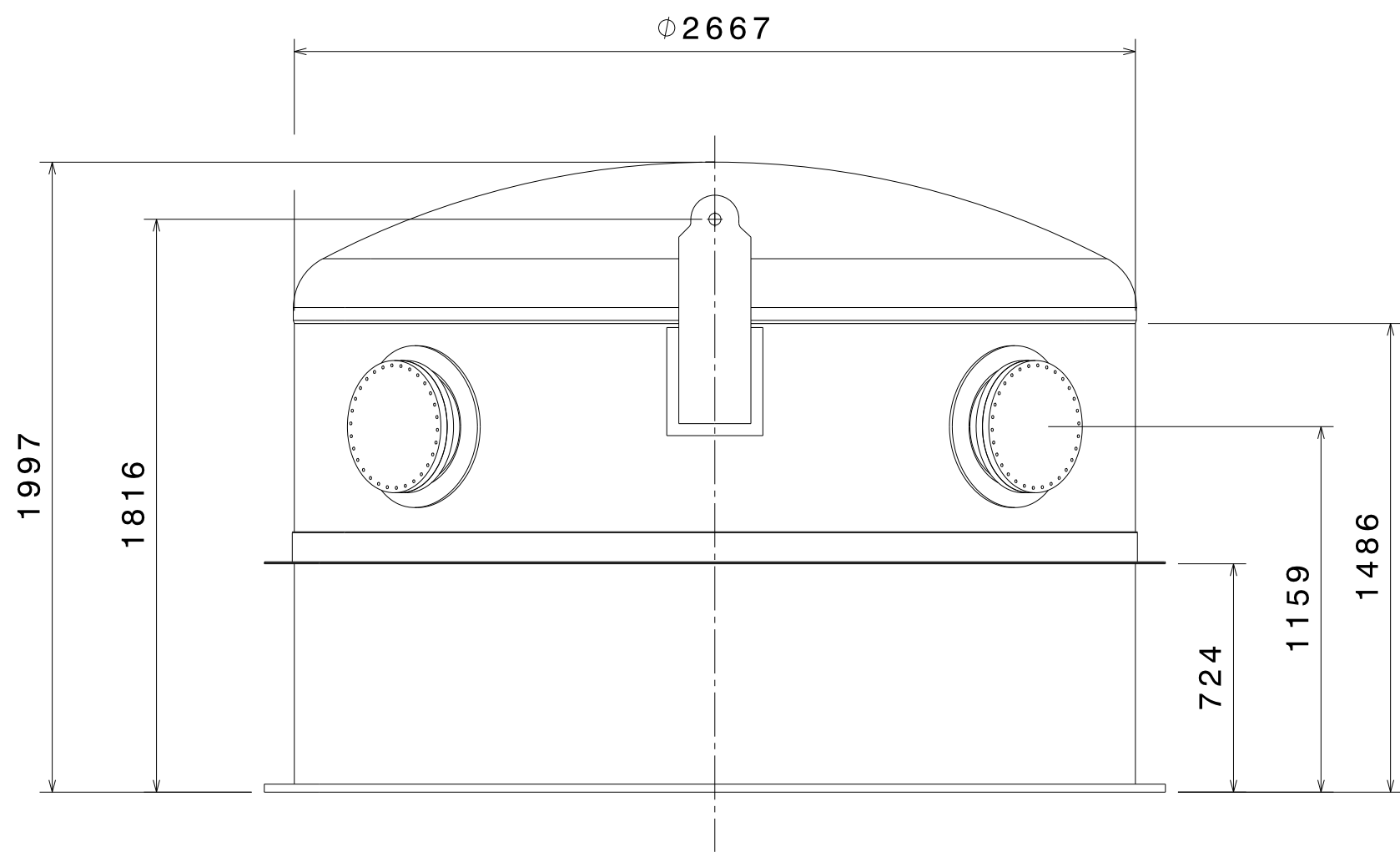


6	01	DN 200CF BLANK FLANGE	SS304L	V001 -001 -R0 /SHEET 01	
5	01	DN 200CF COVER FLANGE	SS304L	V001 -001 -R0 /SHEET 01	-
4	01	PORT NOZZLE	SS304L	VB01 -005 -R1 /SHEET 03	-
3	04	LIFTING LUG	SS304L	VB01 -005 -R1 /SHEET 03	-
2	01	FLANGE FLAT (60.5" ID)	SS304L	VB01 -005 -R1 /SHEET 03	-
1	01	F & D HEAD	SS304L	VB01 -006 -R1 /SHEET 01	
PART NO.	QUANTITY	PART NAME	MATERIAL	REF. DWG. NO.	REMARK

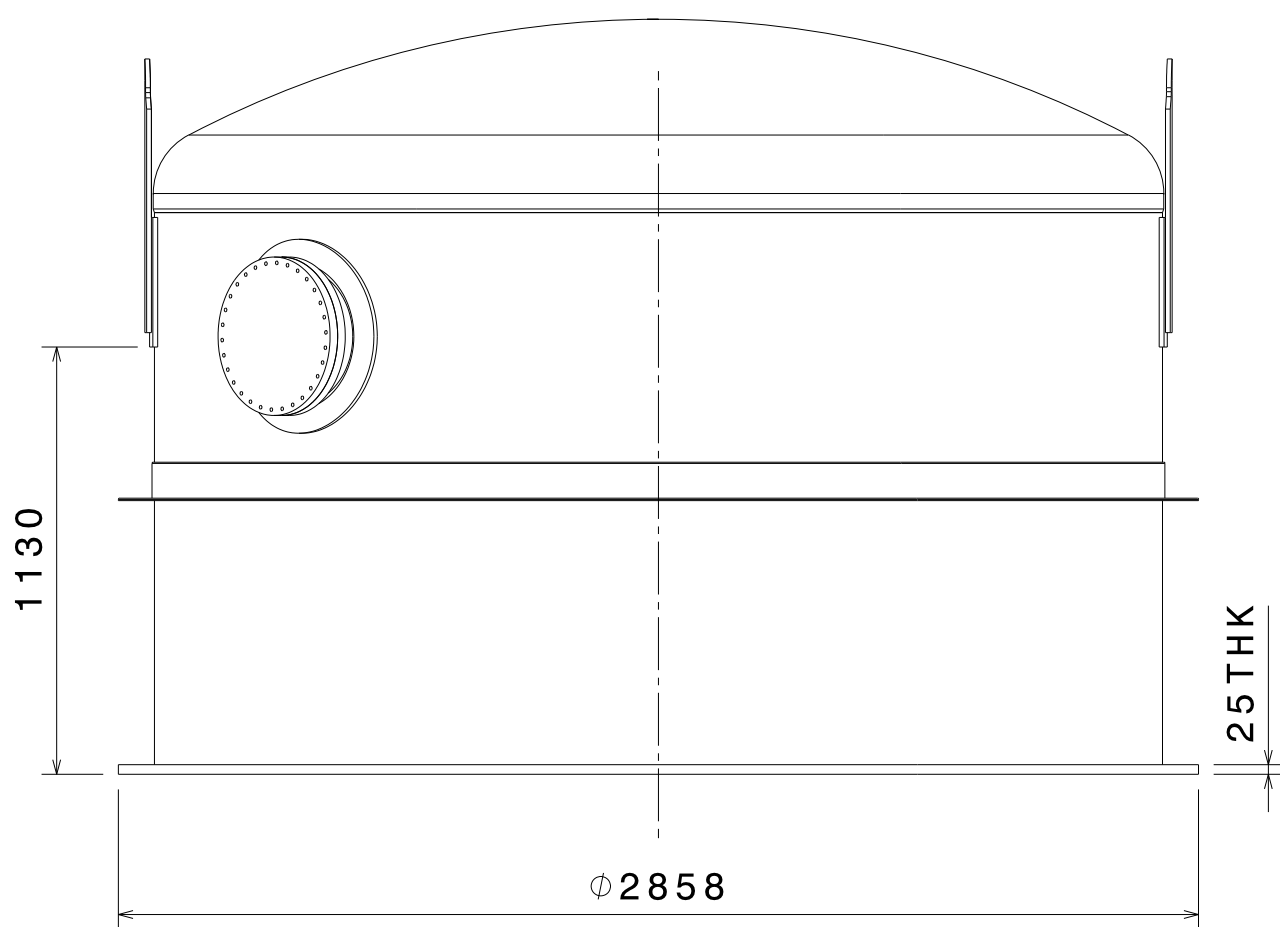
MATERIAL:				▽ 8-25 ▽▽ 1.6-B ▽▽▽ 0.025-1.6 ▽▽▽▽ < 0.025				REVISION COLUMN							MED		SIZE A1		INSTITUTE FOR PLASMA RESEARCH (LIGO-INDIA) BHAT, GANDHINAGAR-382 428.	
CO-ORDINATED BY								REV	ZONE	DESCRIPTION	DATE	REMARKS	APPROVED BY	ALL DIMENSIONS ARE IN "mm" UNLESS OTHERWISE STATED						
MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS															SCALE	1:10	DATE	TITLE END COVER TYPE-A11		
LENGTH IN mm OF SHORTER SIDE OF ANGLES				LENGTH OR DIA	UPTO 6	6-30	30-120	120-315						DRAWN	A.N.N.	11/07/2016				
UPTO 10	10-50	50-120	OVER 120-400											CHECKED	R.K.		REF DRG NO:		VB01-001-R1	REV R1
+1'	+0'-30'	+0'-20'	+0'-10'		+0.1	+0.2	+0.3	+0.5						APPROVED	M.K.G.		DRG.NO		VB01-006-R1	SHEET 01 OF 01



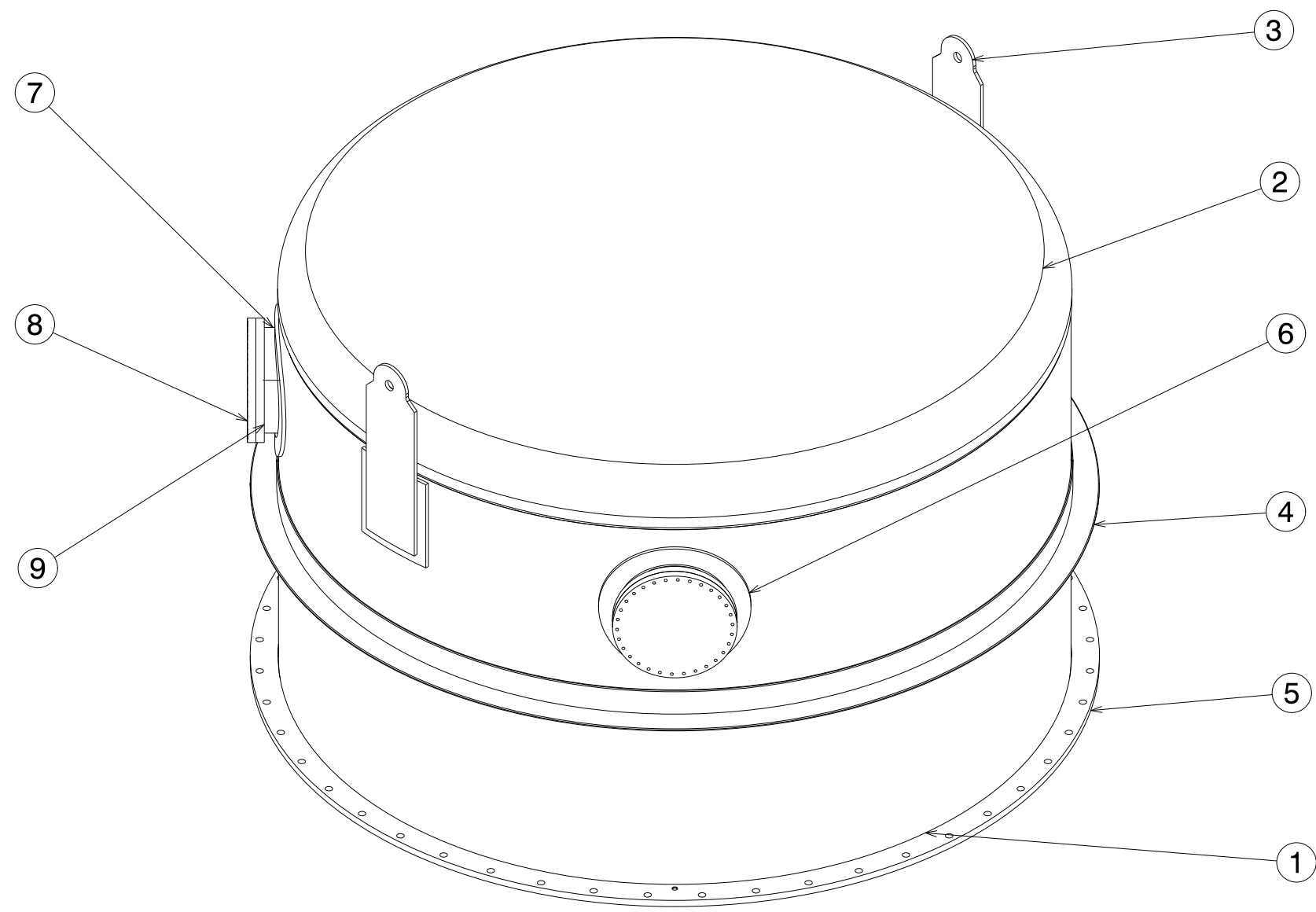
TOP VIEW



FRONT VIEW



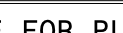
SIDE VIEW

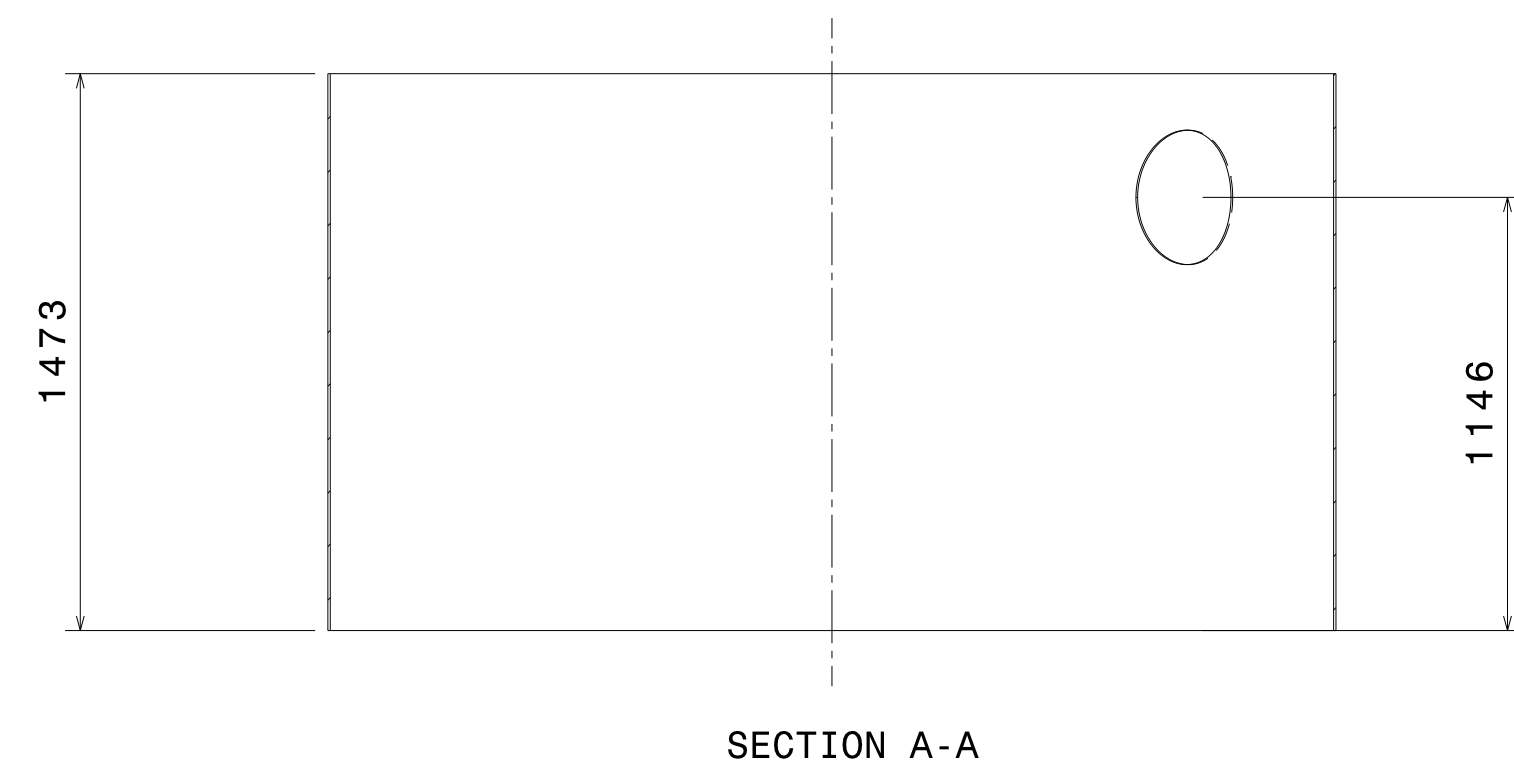
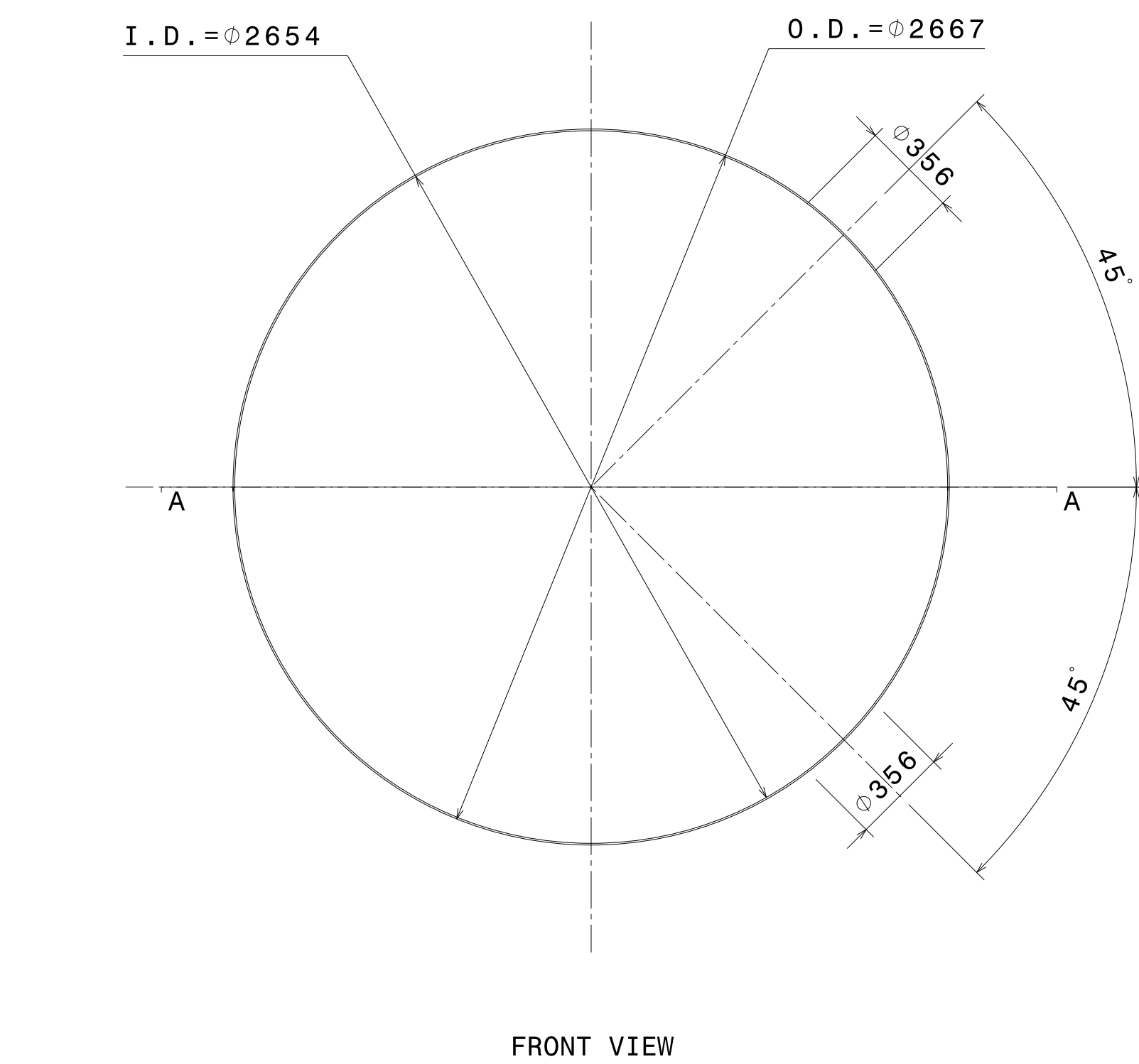


ISOMETRIC VIEW

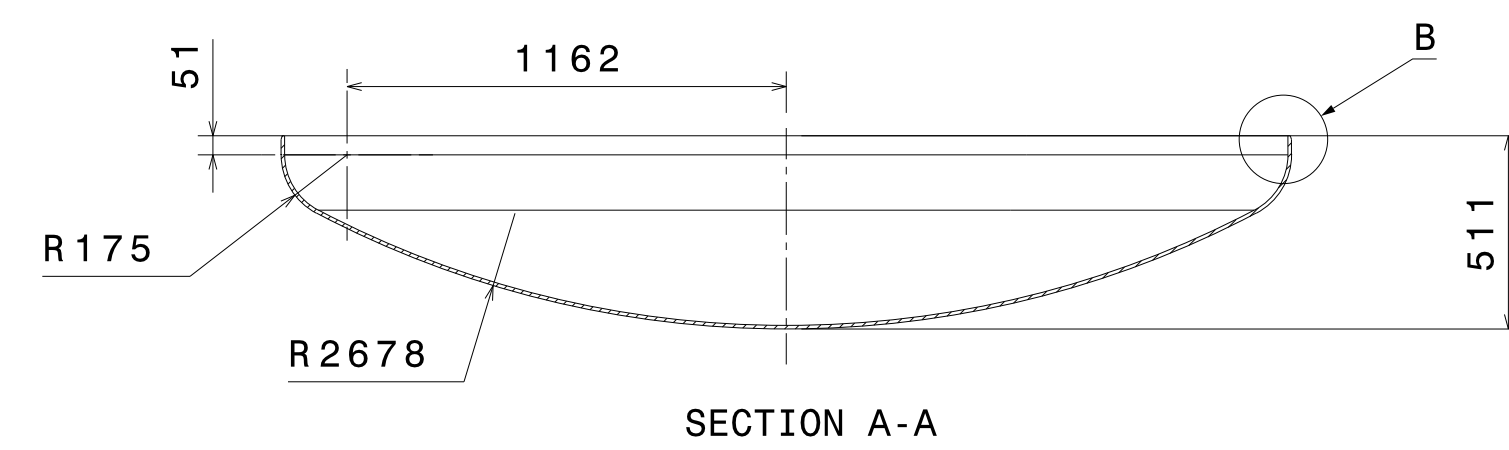
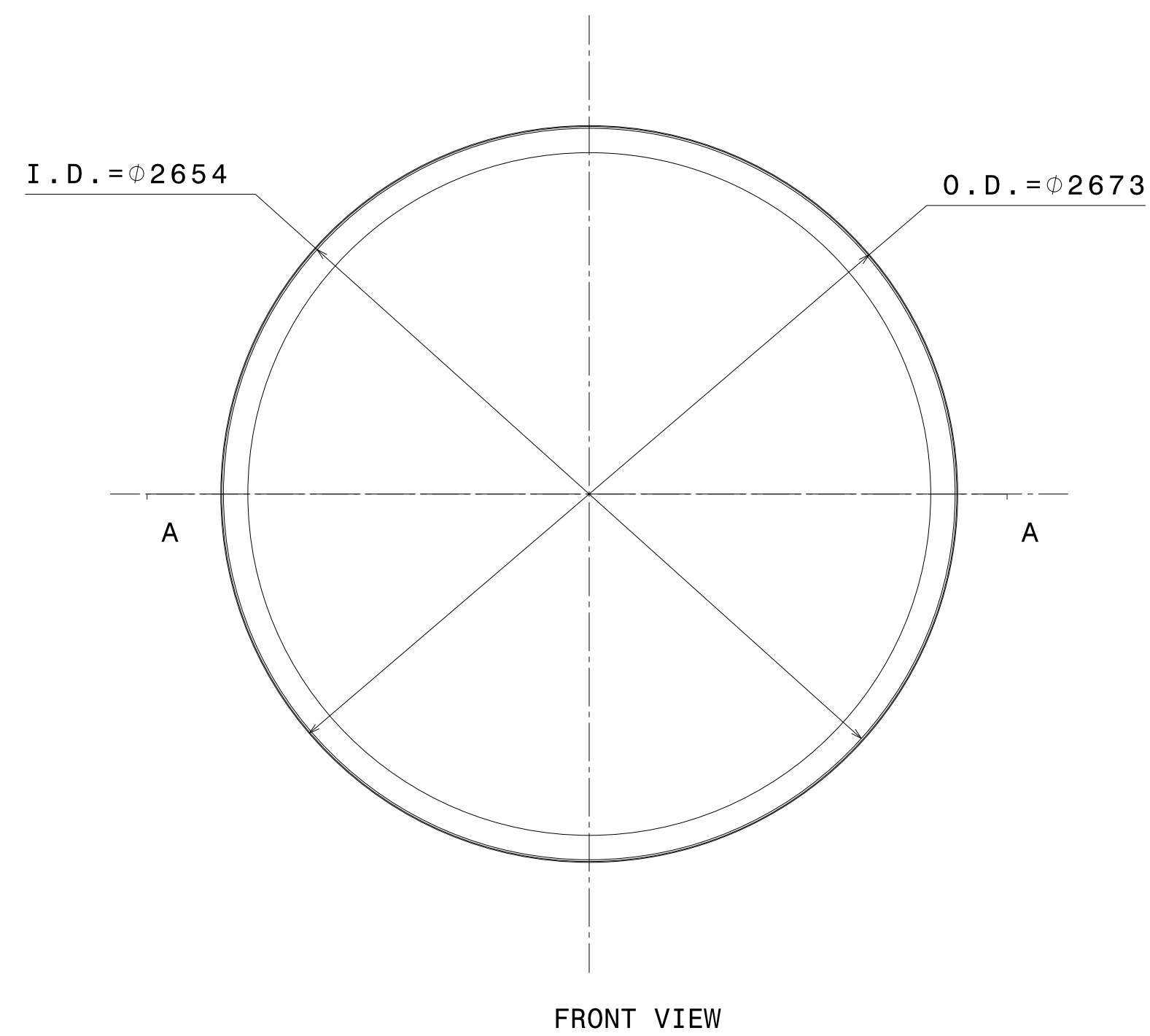
9	02	CUSTOM CF BLANK FLANGE (16 1/2")	SS304L	V001-001-R0/SHEET 04	
8	02	CUSTOM CF COVER FLANGE (16 1/2")	SS304L	V001-001-R0/SHEET 04	-
7	02	PORT NOZZLE	SS304L	VB01-007-R1/SHEET 03	-
6	02	RING NOZZLE	SS304L	VB01-007-R1/SHEET 03	-
5	01	FLANGE FLAT (104.5"ID)	SS304L	VB01-007-R1/SHEET 03	-
4	01	STIFFENER	SS304L	VB01-007-R1/SHEET 03	-
3	02	LIFTING LUG	SS304L	VB01-007-R1/SHEET 03	-
2	01	UPPER F & D HEAD	SS304L	VB01-007-R1/SHEET 02	-
1	01	CYLINDRICAL SHELL	SS304L	VB01-007-R1/SHEET 02	-
PART NO.	QUANTITY	PART NAME	MATERIAL	REF. DWG. NO.	REMARK

5 UPPER PART

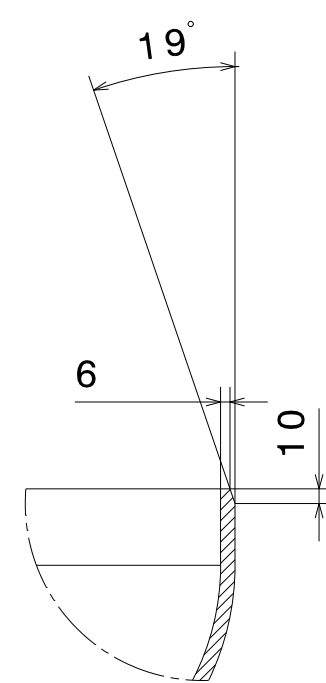
MATERIAL:		▽ 8-25		▽▽ 1.6-8		▽▽▽ 0.025-1.6		▽▽▽▽ < 0.025		REVISION COLUMN							MED		SIZE A1			INSTITUTE FOR PLASMA RESEARCH (LIGO-INDIA)																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																														
CO-ORDINATED BY										REV	ZONE	DESCRIPTION			DATE	REMARKS	APPROVED BY		ALL DIMENSIONS ARE IN "mm" UNLESS OTHERWISE STATED																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																	
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LENGTH IN mm OF SHORTER SIDE OF ANGLES						LENGTH OR DIA	UPTO 6	6-30	30-120		120-315												DRAWN		A.N.N.	12/07/2015	UPPER PART																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																									
UPTO 10	10-50	50-120		OVER 120-400																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																



① CYLINDRICAL SHELL

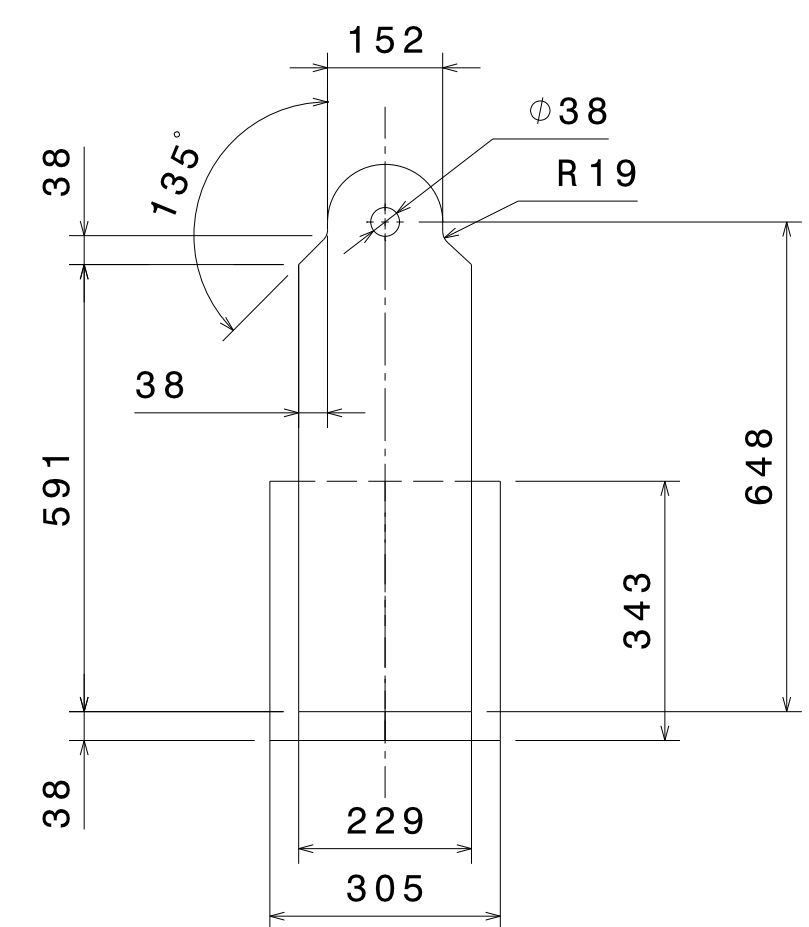


② UPPER F & D HEAD

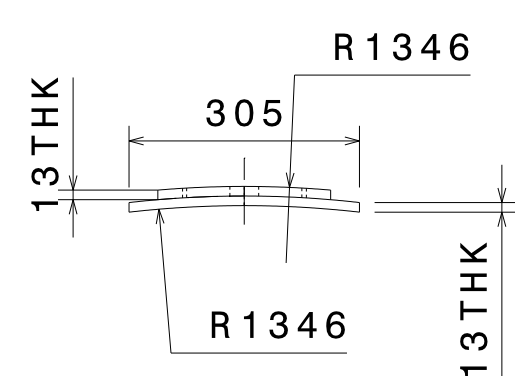


DETAIL VIEW-B
SCALE - 1:5

MATERIAL:		▽ 8-25		▽▽ 1.6-8		▽▽▽ 0.025-1.6		▽▽▽▽ < 0.025		REVISION COLUMN							MED		SIZE A1		 INSTITUTE FOR PLASMA RESEARCH (LIGO-INDIA) BHAT, LANGHINAGAR-382 428.	
CO-ORDINATED BY										REV	ZONE	DESCRIPTION		DATE	REMARKS	APPROVED BY	ALL DIMENSIONS ARE IN "mm" UNLESS OTHERWISE STATED					
MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS																		SCALE	1:20	DATE	 TITLE	UPPER PART
LENGTH IN mm OF SHORTER SIDE OF ANGLES				LENGTH OR DIA	UPTO 6	6-30	30-120	120-315									DRAWN	A.N.N.	12/07/2016			
UPTO 10	10-50	50-120	OVER 120-400														CHECKED	R.K.		REF DRG NO: VB01-001-R1	REV R1	
±1"	±0'-30'	±0'-20'	±0'-10'		±0.1	±0.2	±0.3	±0.5									APPROVED	M.K.G.		DRG. NO	VB01-007-R1	SHEET 02 OF 03

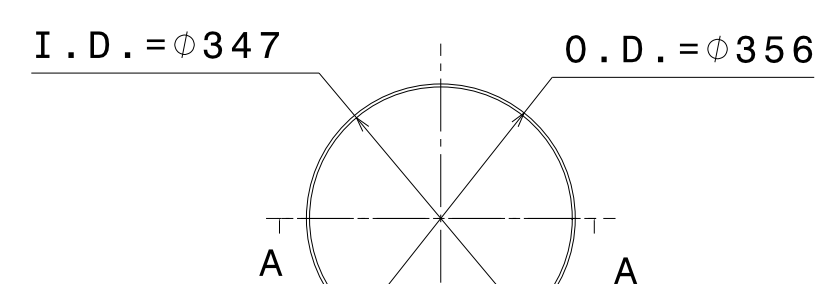


FRONT VIEW

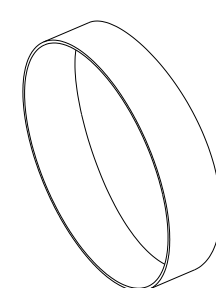


BOTTOM VIEW

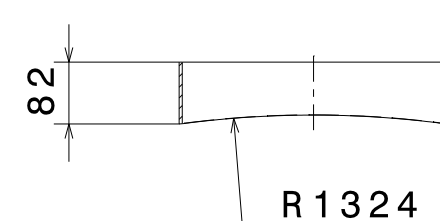
③ LIFTING LUG
SCALE - 1:10



FRONT VIEW

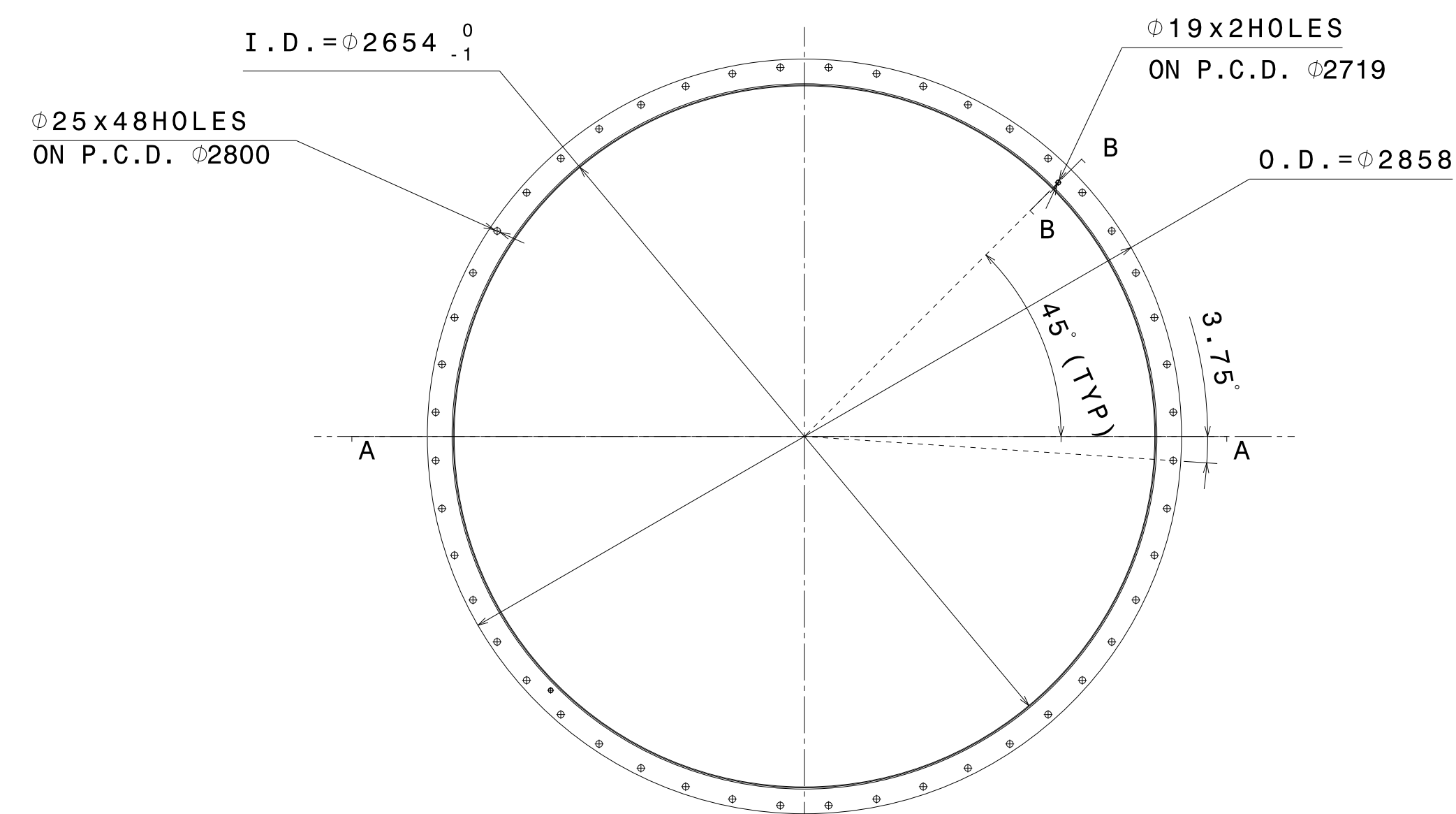


ISOMETRIC VIEW

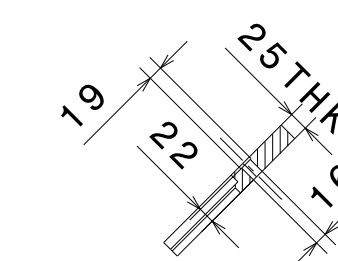


SECTION A-A

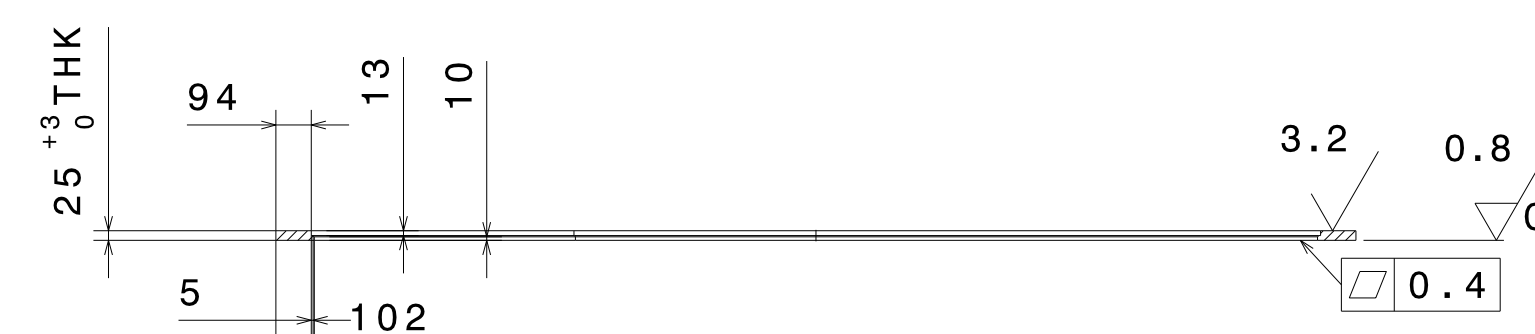
⑦ PORT NOZZLE
SCALE-1:10



FRONT VIEW

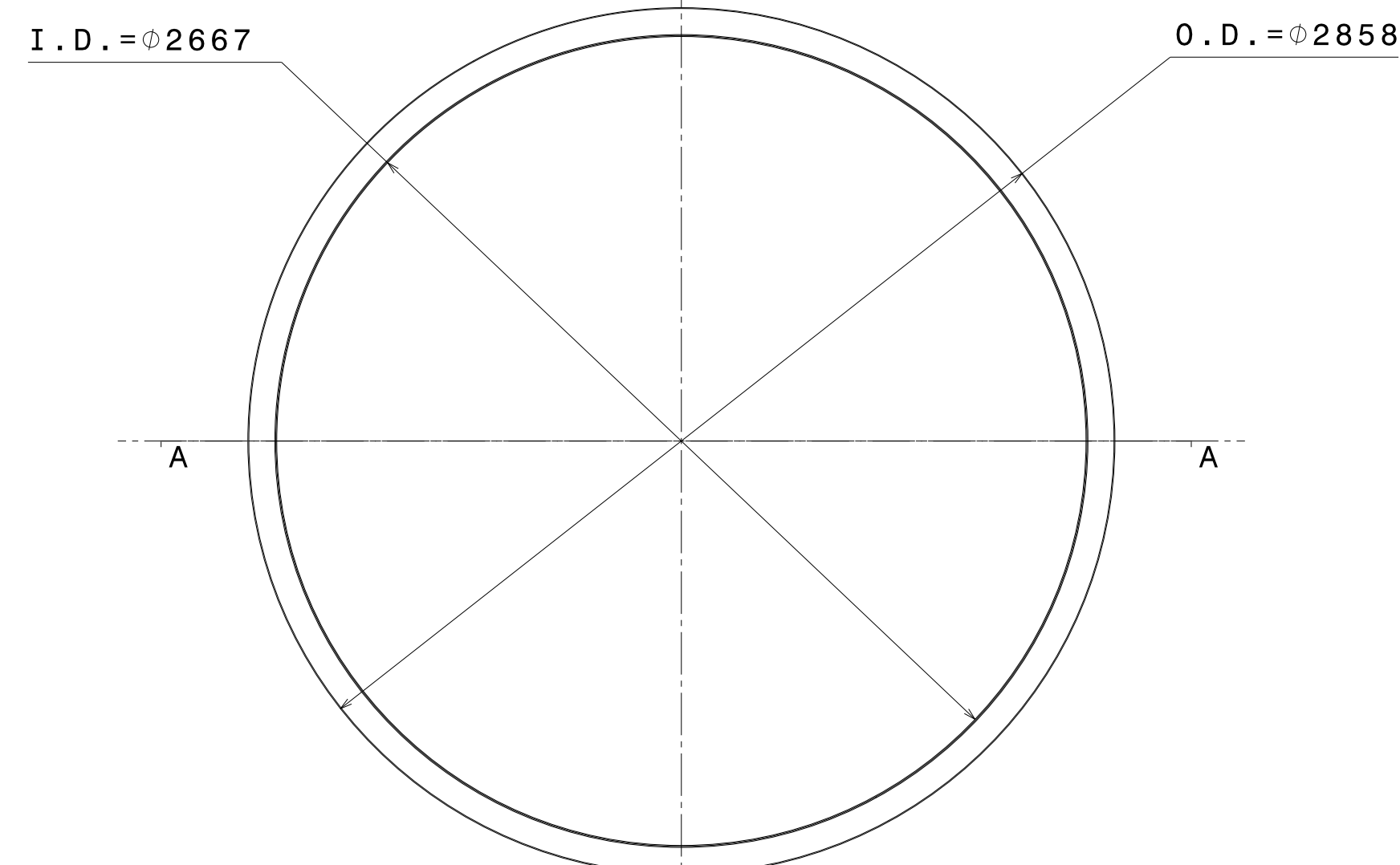


SECTION B-B
1:10

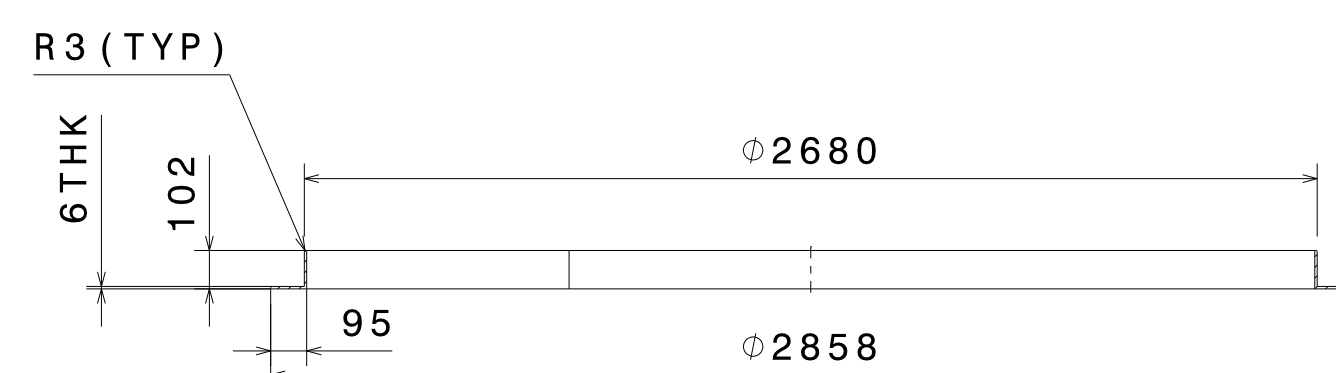


SECTION A-A

⑤ FLANGE FLAT (104.5"ID)
SCALE-1:20

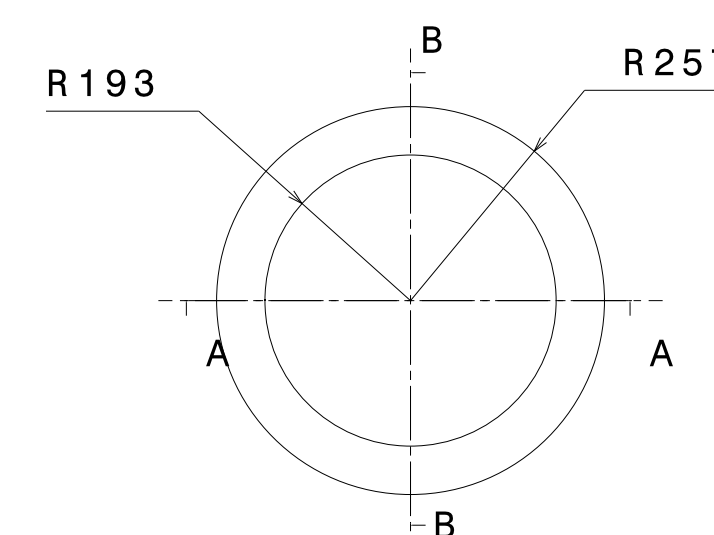


FRONT VIEW

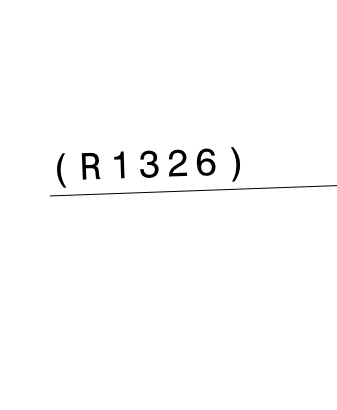


SECTION A-A

④ STIFFENER
SCALE - 1 : 20



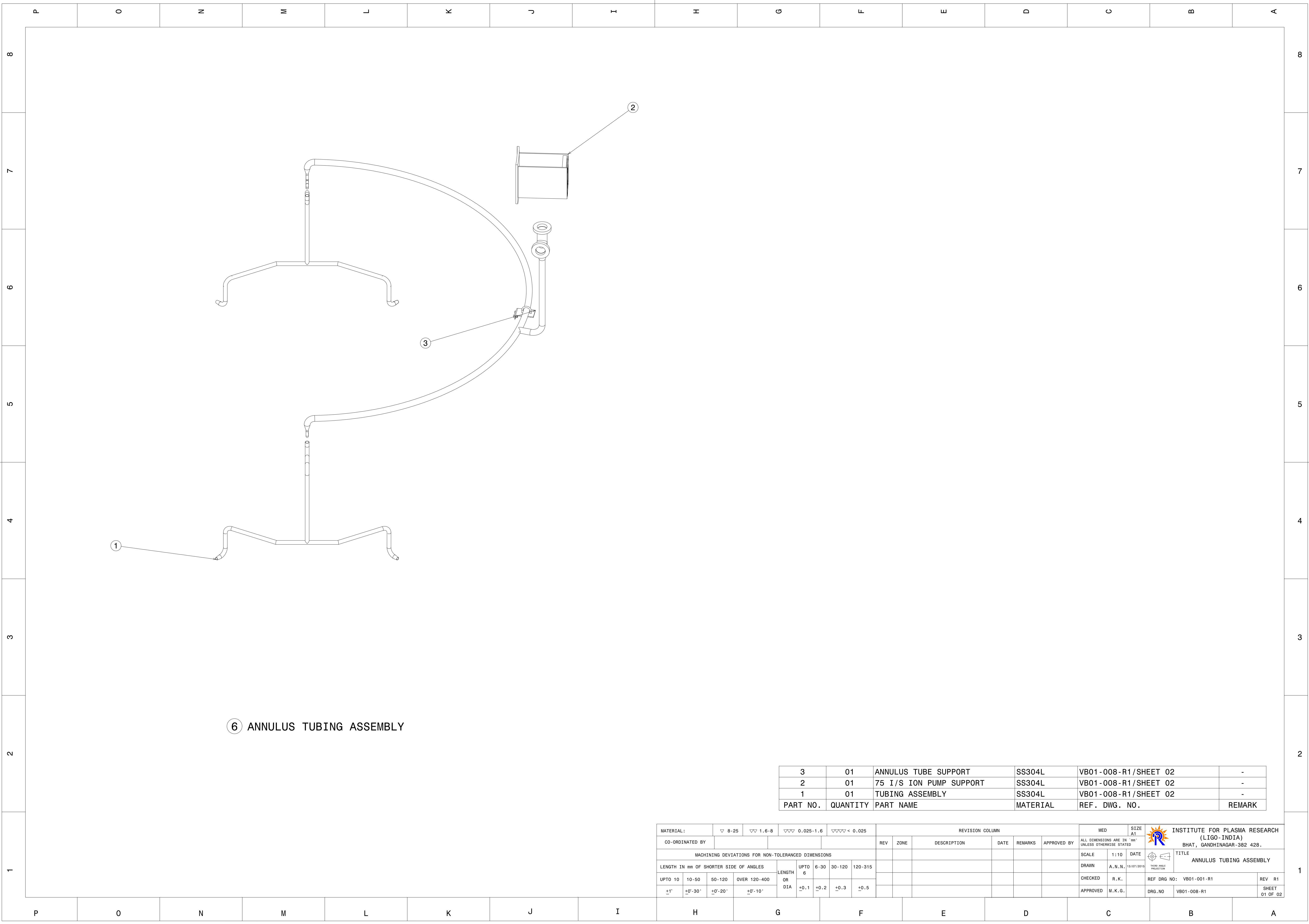
FRONT VIEW



SECTION B-B

⑥ RING NOZZLE
SCALE-1:10

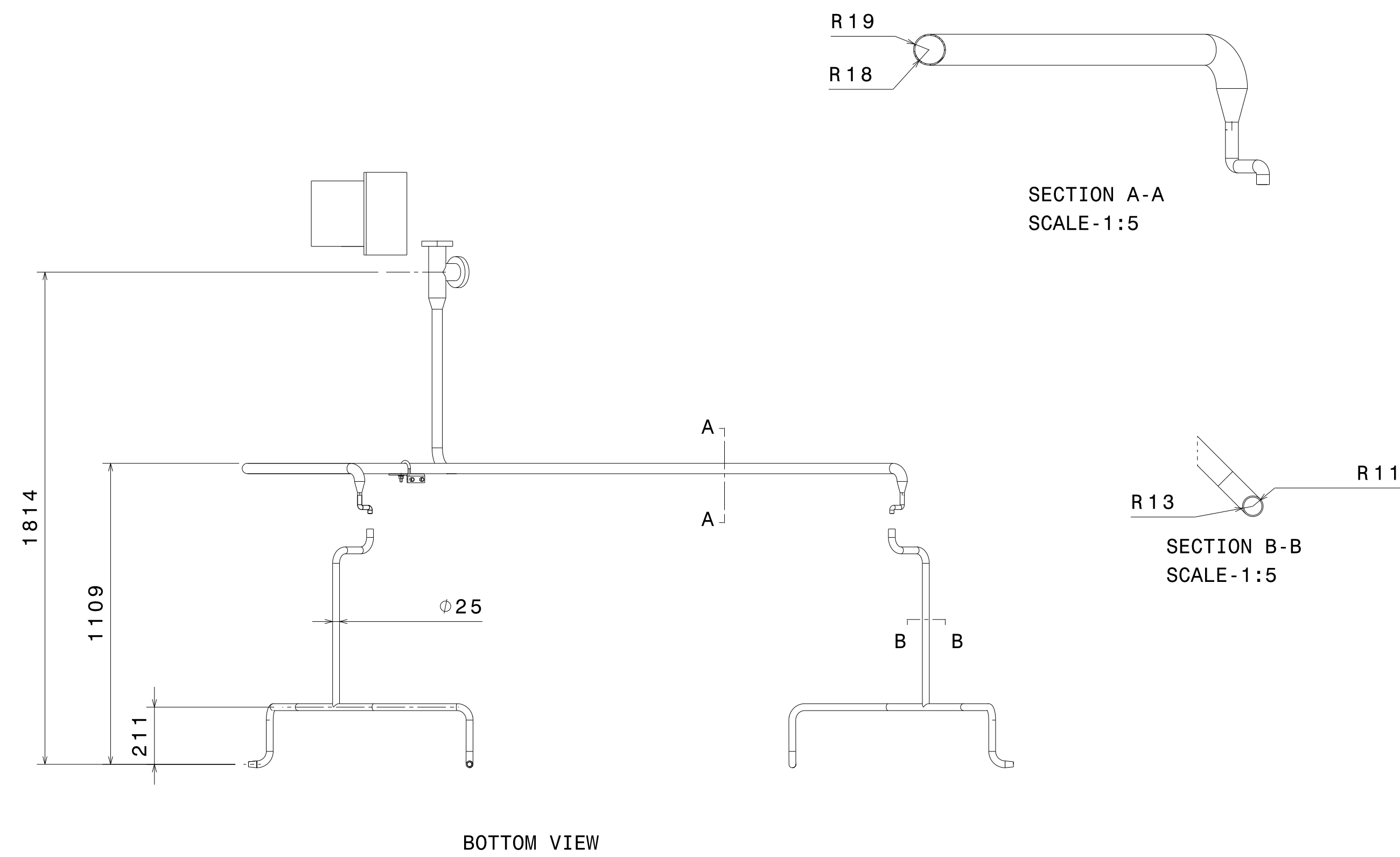
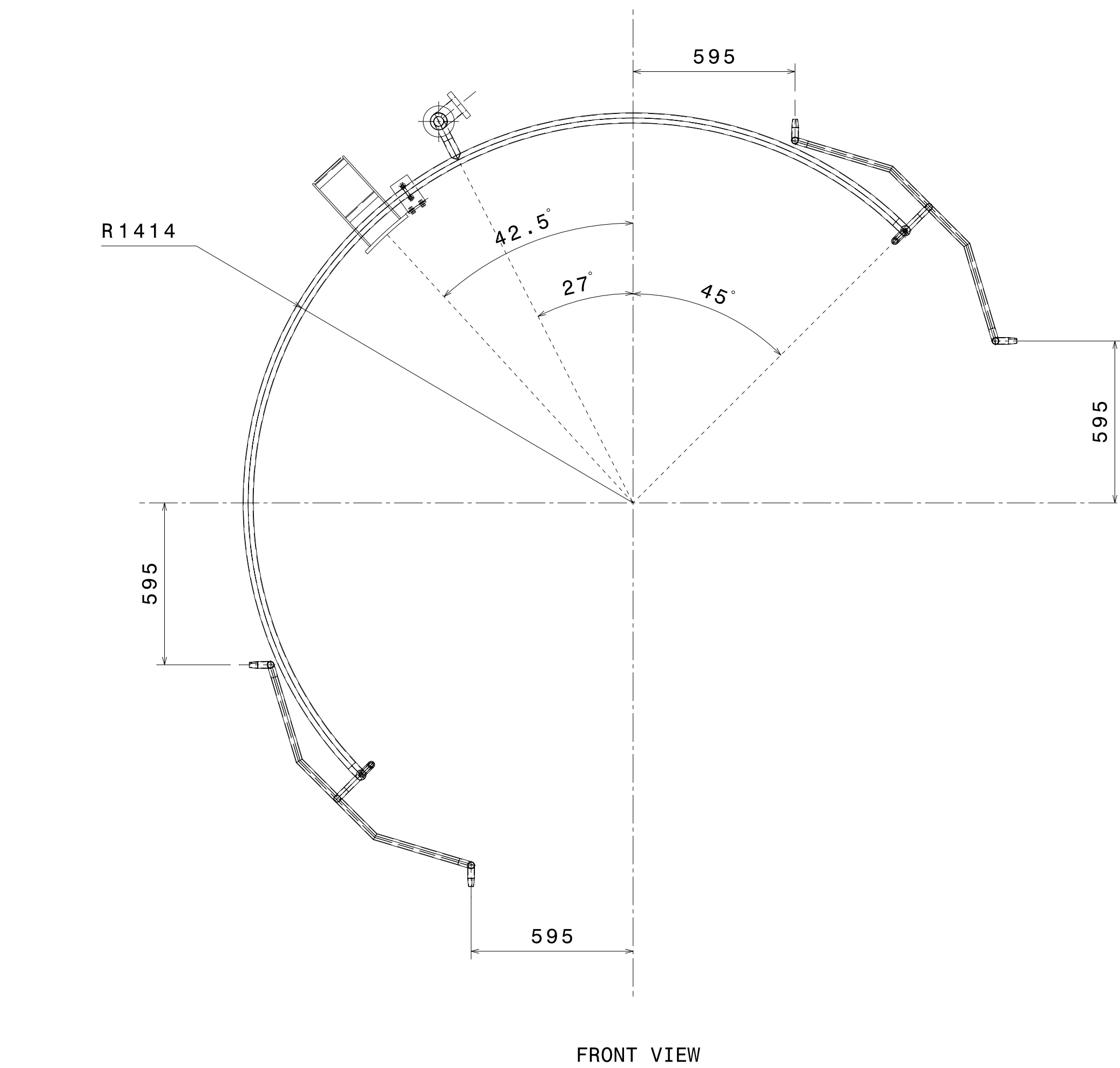
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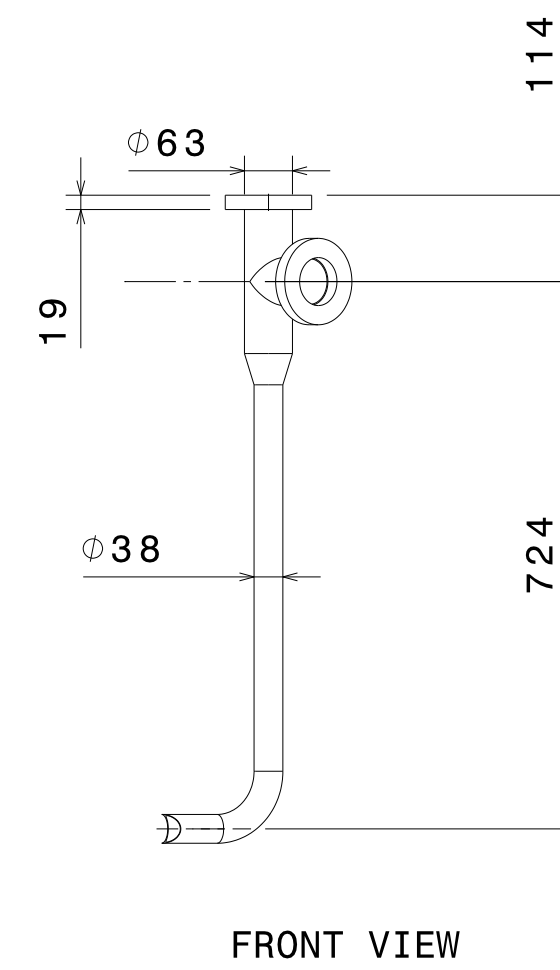
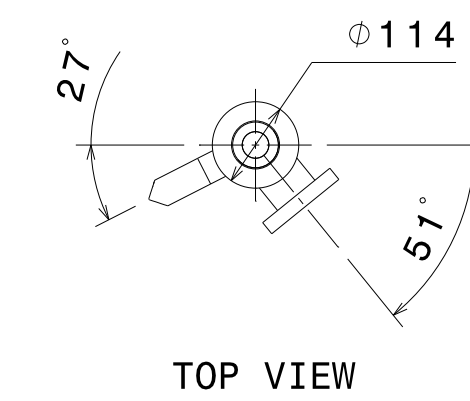
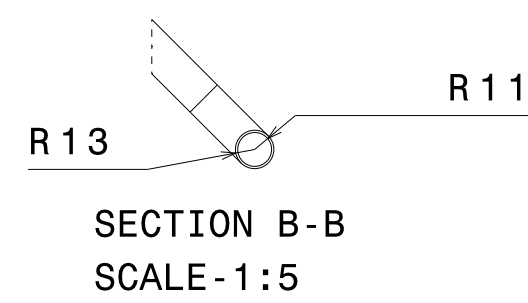
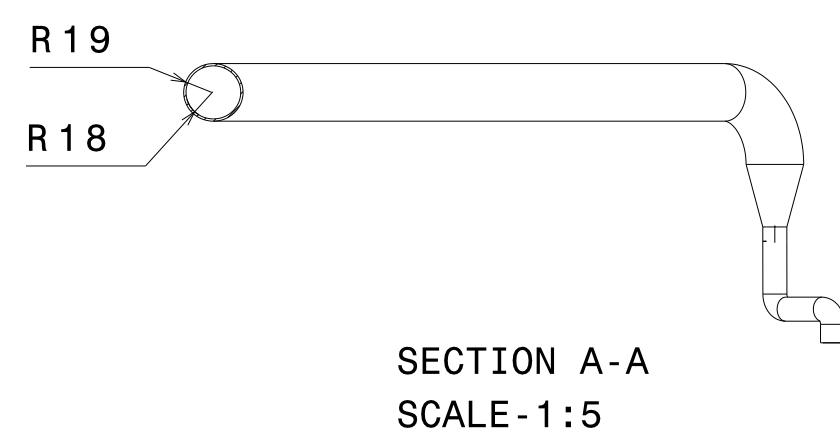
6 ANNULUS TUBING ASSEMBLY

3	01	ANNULUS TUBE SUPPORT	SS304L	VB01-008-R1/SHEET 02	-
2	01	75 I/S ION PUMP SUPPORT	SS304L	VB01-008-R1/SHEET 02	-
1	01	TUBING ASSEMBLY	SS304L	VB01-008-R1/SHEET 02	-
PART NO.	QUANTITY	PART NAME	MATERIAL	REF. DWG. NO.	REMARK

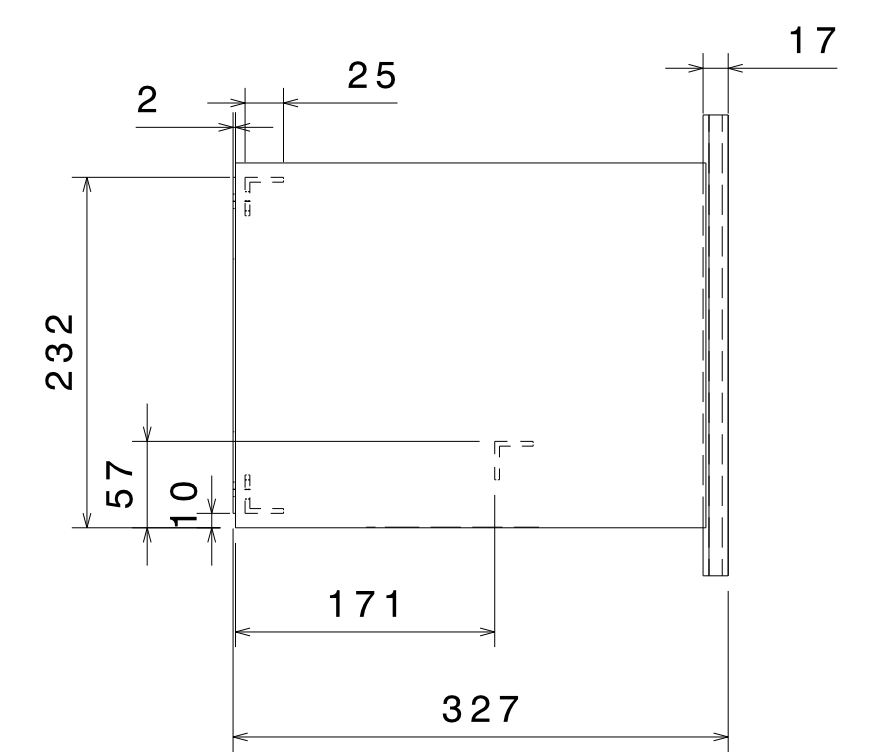
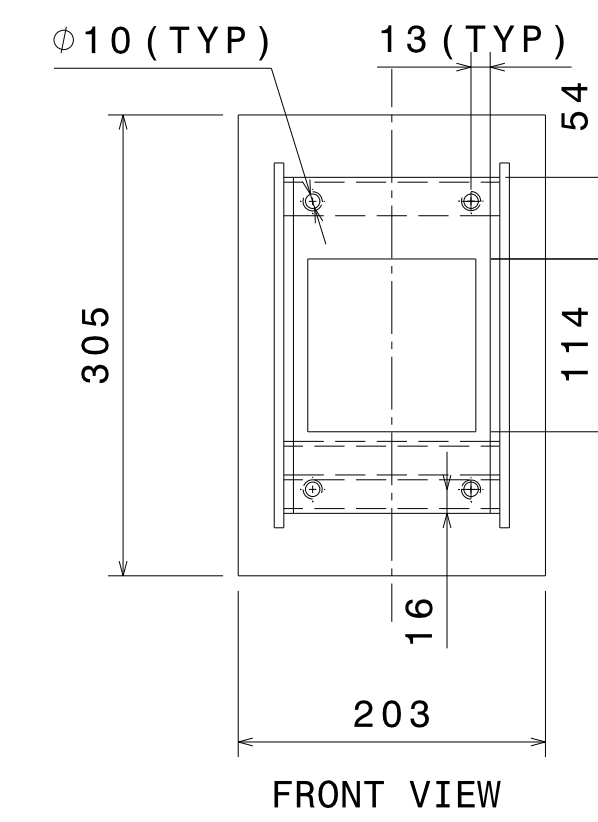
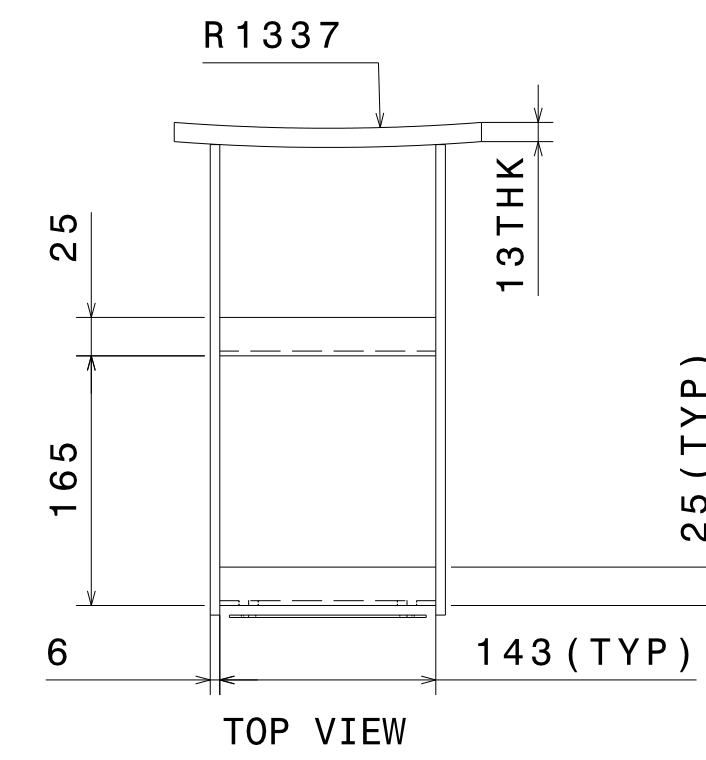
MATERIAL:		▽ 8-25		▽▽ 1.6-8		▽▽▽ 0.025-1.6		▽▽▽▽ < 0.025		REVISION COLUMN						MED		SIZE A1	 INSTITUTE FOR PLASMA RESEARCH (LIGO-INDIA) BHAT, GANDHINAGAR-382 428.							
CO-ORDINATED BY										REV	ZONE	DESCRIPTION	DATE	REMARKS	APPROVED BY	ALL DIMENSIONS ARE IN "mm" UNLESS OTHERWISE STATED										
MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS																					SCALE		1:10	DATE	TITLE	
LENGTH IN mm OF SHORTER SIDE OF ANGLES				LENGTH OR DIA	UPTO 6	6-30	30-120	120-315											DRAWN	A.N.N.	13/07/2015		ANNULUS TUBING ASSEMBLY			
UPTO 10	10-50	50-120	OVER 120-400																CHECKED	R.K.		REF DRG NO:	VB01-001-R1			REV R1
+1'	+0'-30'	+0'-20'	+0'-10'		+0.1	+0.2	+0.3	+0.5											APPROVED	M.K.G.		DRG. NO	VB01-008-R1	SHEET 01 OF 02		



① TUBING ASSEMBLY
SCALE - 1:15

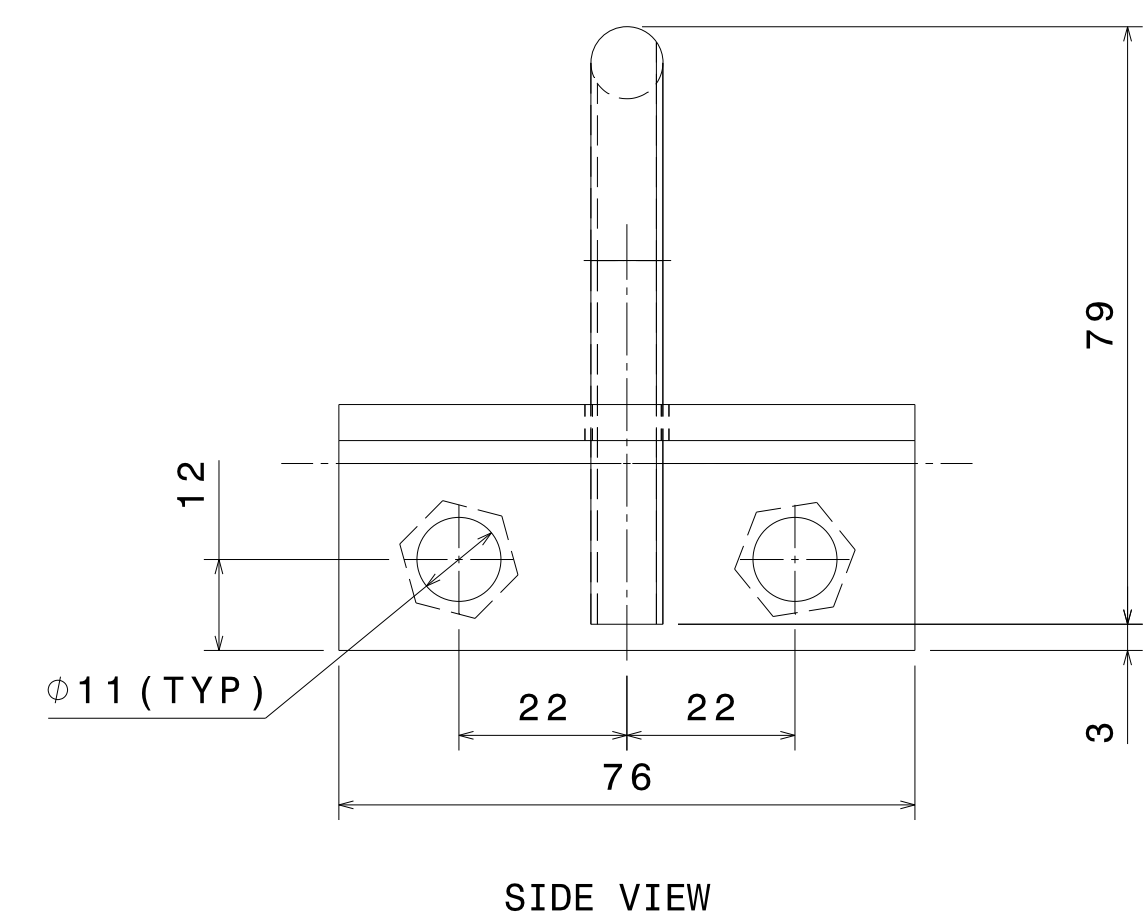
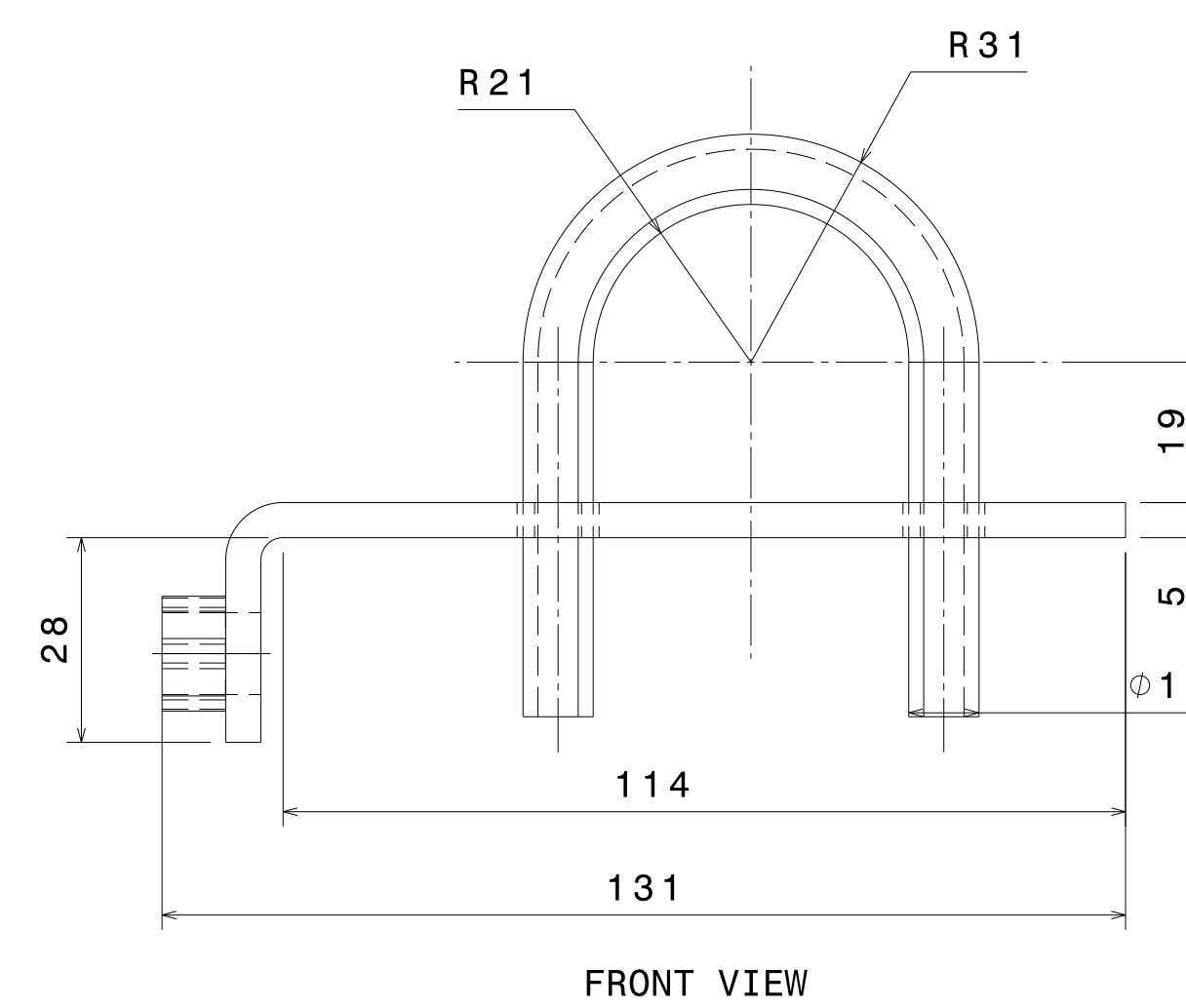


PIPE

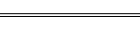


SUPPORT

② 75 I/S ION PUMP SUPPORT
SCALE-1:5



③ ANNULUS TUBE SUPPORT
SCALE-1:1

MATERIAL :		▽ 8-25		▽▽ 1.6-8		▽▽▽ 0.025-1.6		▽▽▽▽ < 0.025		REVISION COLUMN							MED		SIZE A1		 INSTITUTE FOR PLASMA RESEARCH (LIGO-INDIA) BHAT, GANDHINAGAR-382 428.	
CO-ORDINATED BY										REV	ZONE	DESCRIPTION		DATE	REMARKS	APPROVED BY	ALL DIMENSIONS ARE IN "mm" UNLESS OTHERWISE STATED					
MACHINING DEVIATIONS FOR NON-TOLERANCED DIMENSIONS																		SCALE	AS NOTED	DATE	 TITLE ANNULUS TUBING ASSEMBLY	
LENGTH IN mm OF SHORTER SIDE OF ANGLES						LENGTH OR DIA	UPTO 6	6-30	30-120	120-315							DRAWN	A. N. N.	13/07/2016			
UPTO 10	10-50	50-120	OVER 120-400														CHECKED	R. K.				
±1°	±0°-30'	±0°-20'	±0°-10'															REF DRG NO :	VB01-001-R1	REV R1		
																		APPROVED	M. K. G.	DRG. NO		